

SHIP JAN 12TH, 2017

Work Order ID 154264

154264

Page 1

Wednesday, December 07, 2016 10:49:45 A

Item ID: D3479-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Inlet Adapter
 Start Date: 12/9/2016 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 1/6/2017 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: DEC 07 2016 Tooling: _____ Date: _____ Run Start *NR1*
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3479	Rev B								

100
 100
 Small Fab
 Memo 0.00

1-Assemble as per Dwg D3479
 2-Spot Weld as per Dwg D3479 and Dart QSI 018

DAS 6
9-89

LC 16.12.20

110
 110
 QC
 Memo 0.00

QC11-Inspect spot weld per QSI004

② 17.03.02 PD

Quality Control

120
 120
 QC
 Memo 0.00

QC5-Inspect part completeness to step on W/O

② 17.03.02 PD
 Dart FAI attach

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :									
Misidentified ☐	Past Due ☐										

Work Order ID 154264

Wednesday, December 07, 2016 10:49:45 A

154264

Page 2

Item ID: D3479-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Inlet Adapter

Start Date: 12/9/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/6/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: St

0.00

130

Packaging

Memo

0.00

Packaging

2 MAR 03 2017

DAS
6
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

DAS
21
9-89

MAR 03 2017

DAS
21
9-89

MAR 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Wednesday, December 07, 2016 10:49:50 AM

Page 1

Work Order ID: 154264

154264

Parent Item: D3479-041

D3479-041

Parent Item Name: Inlet Adapter

Start Date: 12/9/2016

Required Date: 1/6/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A New Issue 06-02-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D3479-1 ✓ *D3479-1* Tube		Manufactured	No			100	Each	1.0000	1	2			
					B154266				**	2		VS 12/12/19	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz				1					
					67125			1					
D3479-3		Manufactured	No			100	Each	5.0000	1	2			
✓ *D3479-3* Tab, 99 Degrees									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz				5					
					67189			5					
					B154474					2		VS 16/12/19	
D3479-5		Manufactured	No			100	Each	4.0000	1	2			
✓ *D3479-5* Tab, 81 Degrees									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz				4					
					67190			4					
										2		VS 16/12/19	
D3479-7		Manufactured	No			100	Each	6.0000	1	2			
✓ *D3479-7* Flange Plate									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz				6					
					74010			2					
					88335			4					
										2		VS 16/12/19	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

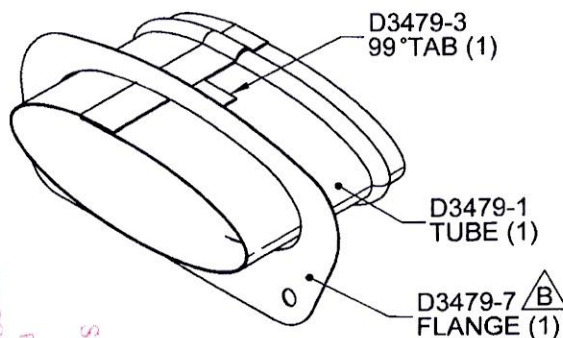
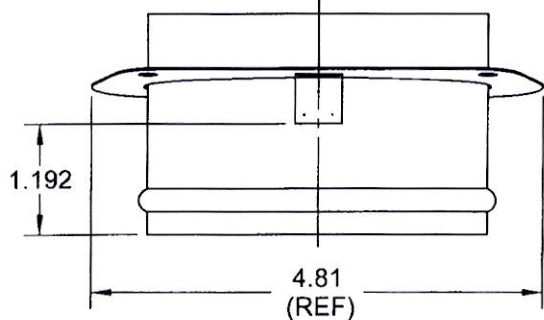
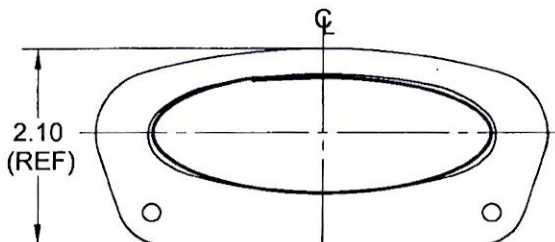
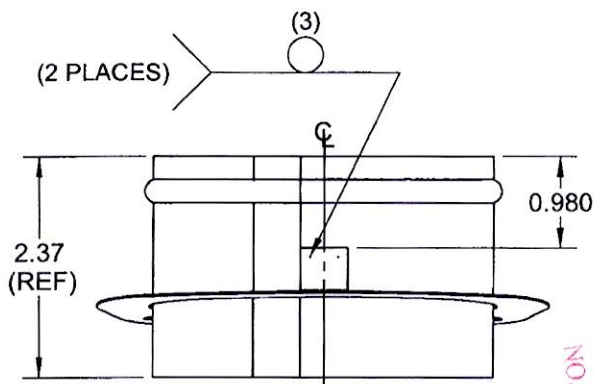
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
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OTHER :																					

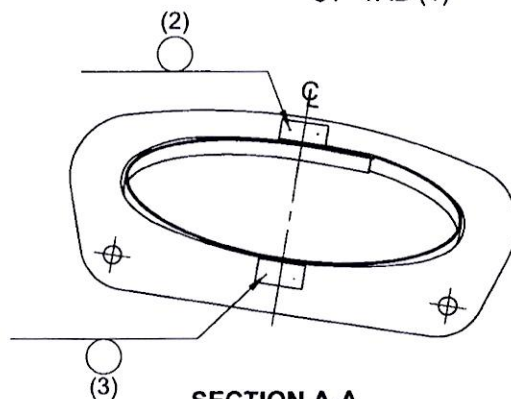
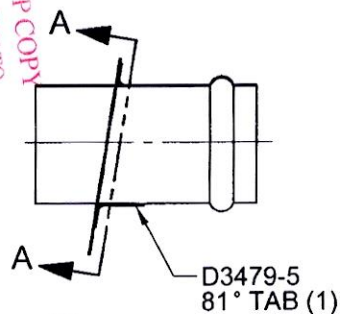


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. B SHEET 1 OF 4
DATE 08.12.19		TITLE INLET ADAPTER	SCALE 1:2
A	06.01.19	NEW ISSUE	
B	08.12.19	CORRECT TYPO ON SHT1; ADD TOL ON SHT2; MATL SPEC WAS MIL-S-5019	

RELEASED
01/01/30



NO. 151264
WORK ORDER
16-12-07
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



SECTION A-A

D3479-041 INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 018
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3479-041	INLET ADAPTER
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34695**

Purchase Order Date 12/24/2016

PO Print Date 1/27/2017

Page Number 1 of 3

Order From : VC-ROY001

RBC ROYAL BANK - VISA
PAYMENT CENTRE, PO BOX 4016, STAT. A
TORONTO, ON M5W 1X6
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name
Vendor Phone

Buyer Linda Lacelle
Customer POID
Customer Tax # 10127-2607
Terms COD
Currency CAD
FOB Destination-Collect

Ship To Contact
Ship To Phone

Ship Via: FedEx Economy collect
Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	154263 spot weld per drwg and QSI004	D3480-041	1/27/2017 Yes 1/27/2017		2.00	\$179.95	\$359.91
						Line Total:	\$359.90
2	154262 spot weld per drwg and QSI004	D3480-043	1/27/2017 Yes 1/27/2017		2.00	\$179.95	\$359.91
						Line Total:	\$359.90
3	154264 spot weld per drwg and QSI004	D3479-041	1/27/2017 Yes 1/27/2017		2.00	\$179.95	\$359.91

DAS
6
9-88
JAN 27 2017
SP

PO Instructions: LEV-FAB
VISA # 4516 0560 0077 4712
CID# 267, EXP 10/20

Note:

1/27/2017



AEROSPACE
LEV-FAB

640 Monseigneur-Dubois Blvd.
St-Jerome, Qc, Canada, J7Y 3L8
Phone: 450-438-7164
Fax: 450-438-9846
www.lev-fab.com



Nadcap



Canada
Controlled Goods program
Programme des marchandises contrôlées

Ship to

DART AEROSPACE
1270 Aberdeen Street
Hawkesbury, Ontario, Canada
K6A 1K7

Packing slip

299

Shipped on Jan 25, 2017

Page 1/1

Customer

1521

DART AEROSPACE
1270 Aberdeen Street
Hawkesbury, Ontario, Canada
K6A 1K7

Contact: Linda Lacelle
Tel: 1 613 632-9577

Fax:

Courriel:

Contact: Linda Lacelle
Tel: 1 613 632-9577 x. 235
Courriel: llacelle@dartaero.com

Fax:

Order date	Payment terms	Customer PO	Order no.	FOB	Freight charges
Dec 20, 2016	C.O.D. 1 ERE COMMANDE	PO34695	229	Origine	Collect

Line	Item	Rev.	Ref. no.	On order	Ship. qty	Back order	PKG
1	D3480-041 EYEBALL ADAPTER	C		2 UN	2		0
2	D3480-043 EYEBALL ADAPTER	C		2 UN	2		0
3	D3479-041 EYEBALL ADAPTER	B		2 UN			2
4	PROCUREMENT-QUALITY PROCUREMENT QUALITY CLAUSE			1 UN	1		0
5	FAI-2-SAMPLES B154684 FAI-2-SAMPLES B154684 PROCESS			1 UN	1		0

DAS
6
9-89

JAN 27 2017

So

Packed by	Date	Name	Carrier name	Pieces	Total
		APOLLO BOUC	VOTRE TRANSPOR		



RÉRONAUTIQUE
LEV-FAB

640 Boul. Mgr Dubois
Saint-Jérôme, QC, J7Y 3L8
Téléphone: 450-438-7164
Ligne Montréal: 514-876-8787
Télécopieur: 450-438-9846
www.lev-fab.com



Nadcap



Canada
Dutied 0000 program
Programme des marchandises certifiées

Bon de livraison ST001607

Imprimé le 2017-01-24

Page 1/1

Fournisseur

A-773

DART AEROSPACE

1270 Aberdeen Street

Hawkesbury, Ontario, Canada

K6A 1K7

Dest.

AER

LEV-FAB Aéronautique

640, Mgr-Dubois

St-Jérôme (Québec) J7Y 3L8

Contact: Linda Lacelle

Tél.: 1 613 632-9577

Fax:

Packed by / Emballé par	Transport	Date d'expéd.
shipping		2017-01-24

Article	Rév.	Descr.	Référence	Qté totale	Poids
D3479-041	B	EYEBALL ADAPTER BEAD PER DART BETWEEN BOTH OPERATION OF SPOT WELD S-trait. ZZ-896 D3479-041-BEAD (PO: A001247)	625-1-41	2 UN	

Signature

Date

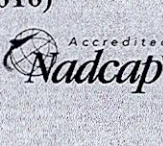


RÉRONAUTIQUE
LEV-FAB

640, boul. Mgr Dubois
Saint-Jérôme (Québec) J7Y 3L8
Téléphone : 450 438-7164

CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE

CLIENT / CUSTOMER www.lev-fab.com		# ORDRE D'ACHAT / PURCHASE ORDER		DATE	
DART AEROSPACE		PO34695		2017-01-24	
# DE LA PIÈCE / PART #		NOM DE LA PIÈCE / PART NAME		# DE SÉRIE / SERIAL NUMBER	
D3480-041		EYEBALL INLET ADAPTER		N/A	
# DESSIN / DRAWING #		REV. DESSIN / DRAWING REV.		CHANGEMENT ADDITIONNEL / ADDITIONAL CHANGE	
D3480		C		N/A	
QUANTITÉ / QUANTITY		# BON DE TRAVAIL / WORK ORDER#		# DE CERTIFICAT / CERTIFICATE #	
2		623-1		623-1	
ADRESSE DE LIVRAISON / SHIPPING ADDRESS					
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 CANADA					
INDEX DES PIÈCES, OPÉRATIONS, INSPECTION POUR RÉALISER SOUS-ASSEMBLAGE OU L'ASSEMBLAGE IDENTIFIÉ PLUS HAUT. INDEX OF PARTS, OPERATIONS, INSPECTION TO CARRY OUT SUBASSEMBLY OR ASSEMBLY IDENTIFIED ABOVE.					
MATIÈRE PREMIÈRE / TRAITEMENT / OPERATION RAW MATERIAL / PROCESS / OPERATIONS		DISTRIBUTEUR / DISTRIBUTOR		RÉSULTAT / # CERTIFICAT RESULT / CERTIFICATE #	
Matière première se référer à l'ordre d'achat Raw material refer to PL D3480 FROM DART AEROSPACE (PART LIST):		DART AEROSPACE		COMPLETED	
- D3480-3 TUBE - D3480-5					
Méthodes / Processes :		LEV-FAB		COMPLETED	
- Processes: Manufacture as per Drawing Requirement or per attached Notification Requirement, if applicable.		LEV-FAB		COMPLETED	
- Spot weld per QSI004		LEV-FAB		COMPLETED	
- Protect for shipment.		LEV-FAB		COMPLETED	
Contrôle Non-Destructif / NDT inspection		N/A		N/A	
Inspection premier article / First article inspection		LEV-FAB		COMPLETED	
Je certifie par la présente que l'article énuméré ci-dessus est conforme, après inspection et essai, aux dessins et aux spécifications indiqués ou cités sur votre bon de commande. I hereby certify, that above article has been inspected and tested and conforms to the drawings and/or specification quoted on, or referenced by your Purchase Order.					
Signature				Date 2017-01-24	

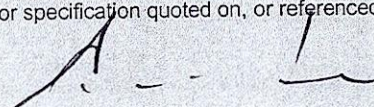




RÉRONAUTIQUE
LEV-FAB

640, boul. Mgr Dubois
Saint-Jérôme (Québec) J7Y 3L8
Téléphone : 450 438-7164

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

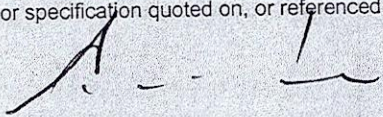
CLIENT / CUSTOMER 438-9940 www.lev-fab.com DART AEROSPACE		# ORDRE D'ACHAT / PURCHASE ORDER PO34695		DATE 2017-01-24
# DE LA PIÈCE / PART # D3480-041		NOM DE LA PIÈCE / PART NAME EYEBALL INLET ADAPTER		# DE SÉRIE / SERIAL NUMBER N/A
# DESSIN / DRAWING # D3480		REV. DESSIN / DRAWING REV. C	CHANGEMENT ADDITIONNEL / ADDITIONAL CHANGE N/A	
QUANTITÉ / QUANTITY 2		# BON DE TRAVAIL / WORK ORDER# 623-1		# DE CERTIFICAT / CERTIFICATE # 623-1
ADRESSE DE LIVRAISON / SHIPPING ADDRESS DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 CANADA				
INDEX DES PIÈCES, OPÉRATIONS, INSPECTION POUR RÉALISER SOUS-ASSEMBLAGE OU L'ASSEMBLAGE IDENTIFIÉ PLUS HAUT. INDEX OF PARTS, OPERATIONS, INSPECTION TO CARRY OUT SUBASSEMBLY OR ASSEMBLY IDENTIFIED ABOVE.				
MATIÈRE PREMIÈRE / TRAITEMENT / OPERATION RAW MATERIAL / PROCESS / OPERATIONS		DISTRIBUTEUR / DISTRIBUTOR	RÉSULTAT / # CERTIFICAT RESULT / CERTIFICATE #	
Matière première se référer à l'ordre d'achat Raw material refer to PL D3480 FROM DART AEROSPACE (PART LIST): - D3480-3 TUBE - D3480-5		DART AEROSPACE	COMPLETED	
Méthodes / Processes : - Processes: Manufacture as per Drawing Requirement or per attached Notification Requirement, if applicable. - Spot weld per QSI004 - Protect for shipment.		LEV-FAB LEV-FAB LEV-FAB	COMPLETED COMPLETED COMPLETED	
Contrôle Non-Destructif / NDT inspection		N/A	N/A	
Inspection premier article / First article inspection		LEV-FAB	COMPLETED	
Je certifie par la présente que l'article énuméré ci-dessus est conforme, après inspection et essai, aux dessins et aux spécifications indiqués ou cités sur votre bon de commande. I hereby certify, that above article has been inspected and tested and conforms to the drawings and/or specification quoted on, or referenced by your Purchase Order.				
Signature 			Date 2017-01-24	



AÉRONAUTIQUE
LEV-FAB

640, boul. Mgr Dubois
Saint-Jérôme (Québec) J7Y 3L8
Téléphone : 450 438-7164

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

CLIENT / CUSTOMER www.lev-fab.com DART AEROSPACE		# ORDRE D'ACHAT / PURCHASE ORDER PO34695		DATE 2017-01-24
# DE LA PIÈCE / PART # D3480-041		NOM DE LA PIÈCE / PART NAME EYEBALL INLET ADAPTER		# DE SÉRIE / SERIAL NUMBER N/A
# DESSIN / DRAWING # D3480		REV. DESSIN / DRAWING REV. C	CHANGEMENT ADDITIONNEL / ADDITIONAL CHANGE N/A	
QUANTITÉ / QUANTITY 2		# BON DE TRAVAIL / WORK ORDER# 623-1	# DE CERTIFICAT / CERTIFICATE # 623-1	
ADRESSE DE LIVRAISON / SHIPPING ADDRESS DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 CANADA				
INDEX DES PIÈCES, OPÉRATIONS, INSPECTION POUR RÉALISER SOUS-ASSEMBLAGE OU L'ASSEMBLAGE IDENTIFIÉ PLUS HAUT / INDEX OF PARTS, OPERATIONS, INSPECTION TO CARRY OUT SUBASSEMBLY OR ASSEMBLY IDENTIFIED ABOVE.				
MATIÈRE PREMIÈRE / TRAITEMENT / OPERATION RAW MATERIAL / PROCESS / OPERATIONS		DISTRIBUTEUR / DISTRIBUTOR	RÉSULTAT / # CERTIFICAT RESULT / CERTIFICATE #	
Matière première se référer à l'ordre d'achat Raw material refer to PL D3480 FROM DART AEROSPACE (PART LIST): - D3480-3 TUBE - D3480-5		DART AEROSPACE	COMPLETED	
Méthodes / Processes : - Processes: Manufacture as per Drawing Requirement or per attached Notification Requirement, if applicable. - Spot weld per QSI004 - Protect for shipment.		LEV-FAB LEV-FAB LEV-FAB	COMPLETED COMPLETED COMPLETED	
Contrôle Non-Destructif / NDT inspection		N/A	N/A	
Inspection premier article / First article inspection		LEV-FAB	COMPLETED	
Je certifie par la présente que l'article énuméré ci-dessus est conforme, après inspection et essai, aux dessins et aux spécifications indiqués ou cités sur votre bon de commande. I hereby certify, that above article has been inspected and tested and conforms to the drawings and/or specification quoted on, or referenced by your Purchase Order.				
Signature 			Date 2017-01-24	

PAGE 1 OF 3]

[PAGE 1 OF 3]

VERIFICATION - RAW MATERIALS, SPECIFICATIONS, SPECIAL PROCESSES AND FUNCTIONAL TESTING.

[illegible]

VERIFICATION - RAW MATERIALS, SPECIFICATIONS, SPECIAL PROCESSES AND FUNCTIONAL TESTING.

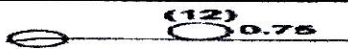
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INSPECTION AND CONTROL (FAI 3) FEATURES, VERIFICATION AND COMFORMANCE EVALUATION

1. PART NUMBER		2. PART NAME		3. SERIAL NUMBER		4. FAI REPORT NUMBER	
D3480-041		EYEBALL INLET ADAPTER		N/A		623-1	
CHARACTERISTIC ACCOUNTABILITY				INSPECTION / TEST RESULTS			
6. CHARC #	6. REFERENCE LOCATION	7. CHARACTERISTIC DESIGNATOR	8. REQUIREMENTS	9. RESULTS	10. DESIGNED TOOLING	11. NON-COMFORMANCE NUMBER	14. COMMENTS
A	N/A	N/A	15° APPROX	15°	RAP. ANGLE 37	N/A	N/A
B	N/A	N/A	ALIGN WELD SEAM OF D3480-3 AS SHOWN	PASS	VISUAL	N/A	N/A
C	N/A	N/A	SPOT WELD PARTS. TRIM D3480-3 FLUSH TO SURFACE OF D3480-5 AS REQUIRED	PASS	VISUAL	N/A	N/A
D	N/A	N/A	1,00 ± 0,030	1,01	VERNIER 207	N/A	N/A
E	N/A	N/A	FORM D3480-3 TO FIT D3480-5	PASS	VISUAL	N/A	N/A
F	N/A	N/A		(12) 0,75	VERNIER 207	N/A	N/A
G	N/A	N/A	D3480-5 FLANGE (1)	PASS	VISUAL	N/A	N/A
H	N/A	N/A	D3480-3 TUBE (1)	PASS	VISUAL	N/A	N/A
I	N/A	N/A	SPOT WELD PER DART QSI 004	PASS	VISUAL	N/A	N/A
J	N/A	N/A	FINISH: NONE	N/A	N/A	N/A	N/A
K	N/A	N/A	IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER	PASS		N/A	N/A
L	N/A	N/A	TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED	PASS		N/A	N/A
M	N/A	N/A	ALL DIMENSIONS ARE IN INCHES	PASS		N/A	N/A
N	N/A	N/A	BREAK ALL SHARP EDGES 0,005 TO 0,010	PASS	FEEL	N/A	N/A
THE SIGNATURE INDICATES THAT ALL CHARACTERISTICS ARE ACCOUNTED FOR; MEET DRAWING REQUIREMENT OR ARE PROPERLY DOCUMENTED FOR DISPOSITION.							
12. PREPARED BY:					13. DATE		

INSPECTION AND CONTROL (FAI 3) FEATURES, VERIFICATION AND COMFORMANCE EVALUATION

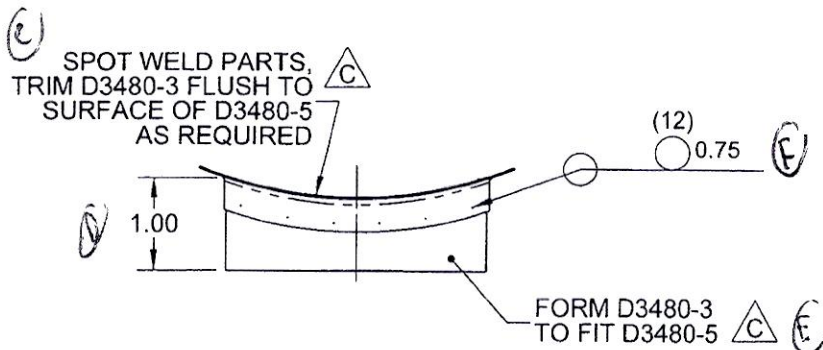
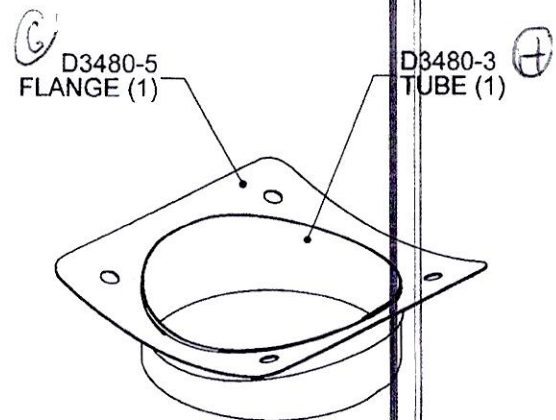
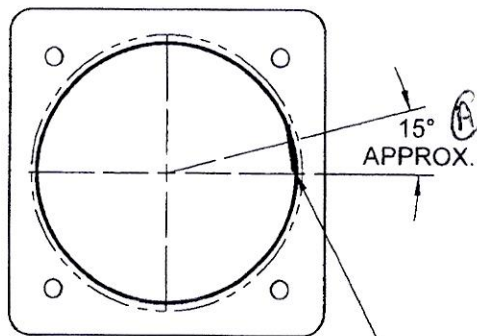
1. PART NUMBER		2. PART NAME		3. SERIAL NUMBER		4. FAI REPORT NUMBER	
D3480-041		EYEBALL INLET ADAPTER		N/A		623-1	
CHARACTERISTIC ACCOUNTABILITY				INSPECTION / TEST RESULTS			
6. CHARC #	6. REFERENCE LOCATION	7. CHARACTERISTIC DESIGNATOR	8. REQUIREMENTS	9. RESULTS	10. DESIGNED TOOLING	11. NON-COMFORMANCE NUMBER	14. COMMENTS
A	N/A	N/A	15° APPROX	15°	RAP. ANGLE 37	N/A	N/A
B	N/A	N/A	ALIGN WELD SEAM OF D3480-3 AS SHOWN	PASS	VISUAL	N/A	N/A
C	N/A	N/A	SPOT WELD PARTS. TRIM D3480-3 FLUSH TO SURFACE OF D3480-5 AS REQUIRED	PASS	VISUAL	N/A	N/A
D	N/A	N/A	1,00 ± 0,030	1,01	VERNIER 207	N/A	N/A
E	N/A	N/A	FORM D3480-3 TO FIT D3480-5	PASS	VISUAL	N/A	N/A
F	N/A	N/A		(12) 0,75	VERNIER 207	N/A	N/A
G	N/A	N/A	D3480-5 FLANGE (1)	PASS	VISUAL	N/A	N/A
H	N/A	N/A	D3480-3 TUBE (1)	PASS	VISUAL	N/A	N/A
I	N/A	N/A	SPOT WELD PER DART QSI 004	PASS	VISUAL	N/A	N/A
J	N/A	N/A	FINISH: NONE	N/A	N/A	N/A	N/A
K	N/A	N/A	IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER	PASS		N/A	N/A
L	N/A	N/A	TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED	PASS		N/A	N/A
M	N/A	N/A	ALL DIMENSIONS ARE IN INCHES	PASS		N/A	N/A
N	N/A	N/A	BREAK ALL SHARP EDGES 0,005 TO 0,010	PASS	FEEL	N/A	N/A
THE SIGNATURE INDICATES THAT ALL CHARACTERISTICS ARE ACCOUNTED FOR; MEET DRAWING REQUIREMENT OR ARE PROPERLY DOCUMENTED FOR DISPOSITION.							
12. PREPARED BY:					13. DATE		

INSPECTION AND CONTROL (FAI 3) FEATURES, VERIFICATION AND COMFORMANCE EVALUATION

1. PART NUMBER		2. PART NAME		3. SERIAL NUMBER		4. FAI REPORT NUMBER	
D3480-041		EYEBALL INLET ADAPTER		N/A		623-1	
CHARACTERISTIC ACCOUNTABILITY				INSPECTION / TEST RESULTS			
6. CHARC #	6. REFERENCE LOCATION	7. CHARACTERISTIC DESIGNATOR	8. REQUIREMENTS	9. RESULTS	10. DESIGNED TOOLING	11. NON-COMFORMANCE NUMBER	14. COMMENTS
A	N/A	N/A	15° APPROX	15°	RAP. ANGLE 37	N/A	N/A
B	N/A	N/A	ALIGN WELD SEAM OF D3480-3 AS SHOWN	PASS	VISUAL	N/A	N/A
C	N/A	N/A	SPOT WELD PARTS. TRIM D3480-3 FLUSH TO SURFACE OF D3480-5 AS REQUIRED	PASS	VISUAL	N/A	N/A
D	N/A	N/A	1,00 ± 0,030	1,01	VERNIER 207	N/A	N/A
E	N/A	N/A	FORM D3480-3 TO FIT D3480-5	PASS	VISUAL	N/A	N/A
F	N/A	N/A		(12) 0,75	VERNIER 207	N/A	N/A
G	N/A	N/A	D3480-5 FLANGE (1)	PASS	VISUAL	N/A	N/A
H	N/A	N/A	D3480-3 TUBE (1)	PASS	VISUAL	N/A	N/A
I	N/A	N/A	SPOT WELD PER DART QSI 004	PASS	VISUAL	N/A	N/A
J	N/A	N/A	FINISH: NONE	N/A	N/A	N/A	N/A
K	N/A	N/A	IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER	PASS		N/A	N/A
L	N/A	N/A	TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED	PASS		N/A	N/A
M	N/A	N/A	ALL DIMENSIONS ARE IN INCHES	PASS		N/A	N/A
N	N/A	N/A	BREAK ALL SHARP EDGES 0,005 TO 0,010	PASS	FEEL	N/A	N/A
THE SIGNATURE INDICATES THAT ALL CHARACTERISTICS ARE ACCOUNTED FOR; MEET DRAWING REQUIREMENT OR ARE PROPERLY DOCUMENTED FOR DISPOSITION.							
12. PREPARED BY:					13. DATE		

DART

DESIGN ↓	DRAWN BY ↓	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ↓	APPROVED ↓	DRAWING NO. D3480	REV. C SHEET 1 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2
A	06.02.06	NEW ISSUE	
B	06.08.29	D3480-3 0.50 was 0.40/D3480-3F 8.930 was 9.330	
C	08.12.19	D3480-3 PICTORIAL CHG PER D3480-3F (SHT 1 & 4); ADD/REV TOL (SHT 3-5); ADD MFG NOTE (SHT 4); MATL SPEC WAS MIL-S-5019	

RELEASE
09/01/30 MP**D3480-041 EYEBALL INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

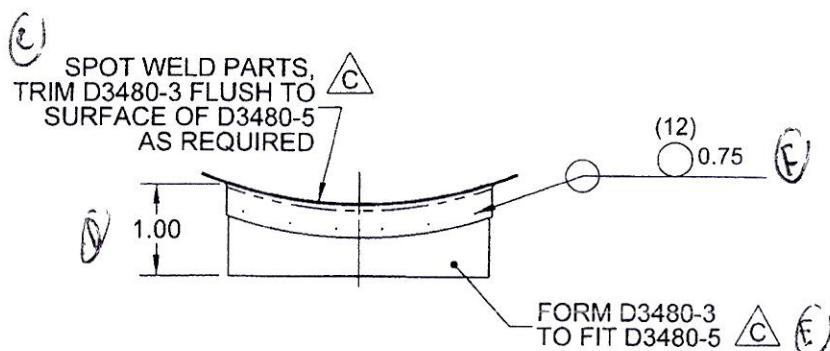
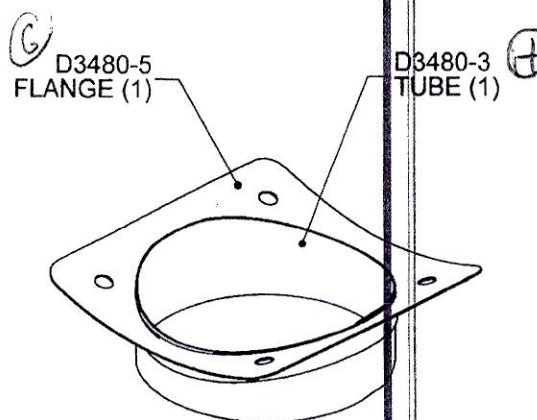
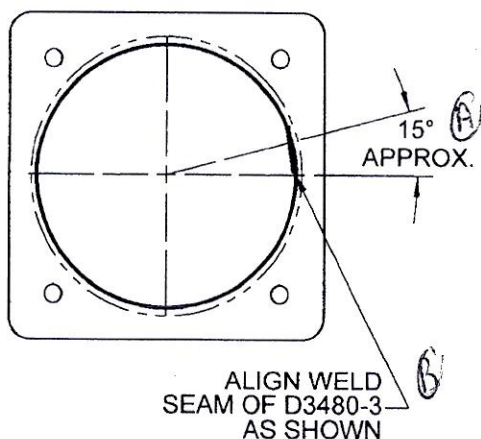
QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED AH	APPROVED H	DRAWING NO. D3480	REV. C SHEET 1 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2
A	06.02.06	NEW ISSUE	
B	06.08.29	D3480-3 0.50 was 0.40/D3480-3F 8.930 was 9.330	
C	08.12.19	D3480-3 PICTORIAL CHG PER D3480-3F (SHT 1 & 4); ADD/REV TOL (SHT 3-5); ADD MFG NOTE (SHT 4); MATL SPEC WAS MIL-S-5019	

RELEASE
09/01/30 MP**D3480-041 EYEBALL INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

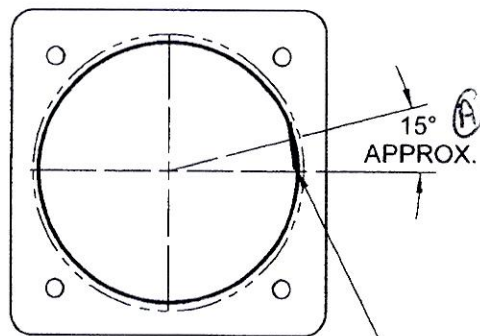
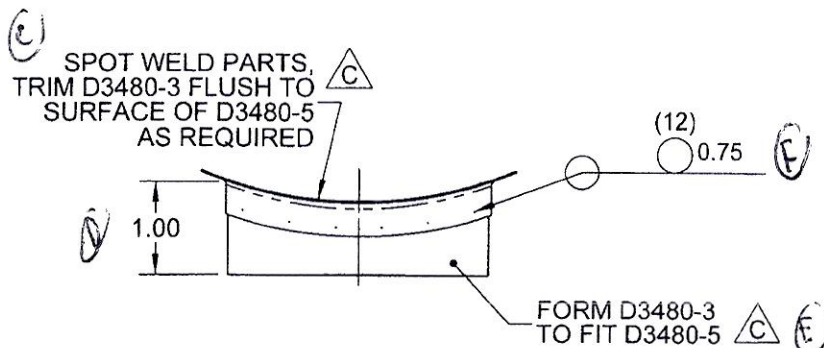
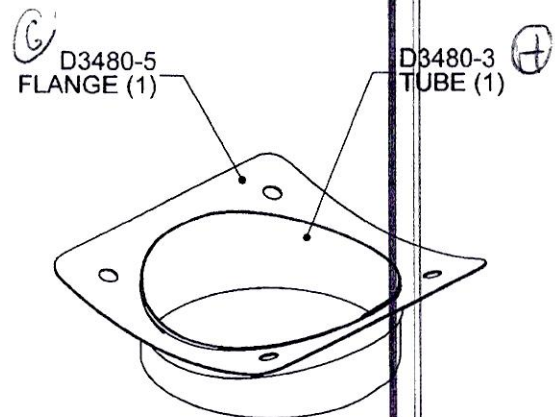
QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. C SHEET 1 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2
A	06.02.06	NEW ISSUE	
B	06.08.29	D3480-3 0.50 was 0.40/D3480-3F 8.930 was 9.330	
C	08.12.19	D3480-3 PICTORIAL CHG PER D3480-3F (SHT 1 & 4); ADD/REV TOL (SHT 3-5); ADD MFG NOTE (SHT 4); MATL SPEC WAS MIL-S-5019	

RELEASE
09/01/30 M/PALIGN WELD
SEAM OF D3480-3
AS SHOWN**D3480-041 EYEBALL INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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RESISTANCE WELDING DATA SHEET AND PQR N° RW-2

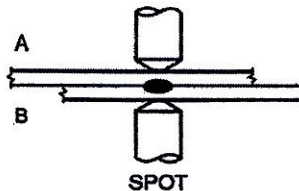
Equipment Identification

Manufacturer: Techno Control

Model: Alpha Series

S/N 3187 Rating 50%

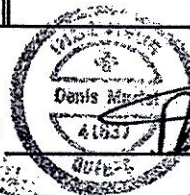
Operator: Frederick Gaudreau



		SIDE A	SIDE B		
MATERIAL	Thickness	0.018"	0.018"	S.C.R.	On
	Approx. Analysis (type)			Squeeze Time (s)	60
				Cool Time (s)	0
	Surface Cond.	Clean *	Clean *	Heat (%)	45
	Ultimate Strength	N/A	N/A	Hold Time (s)	6
	Yield Strength	N/A	N/A	Off Time (s)	6
	Elongation %	---	---	Squeeze Force (Psi)	45
	Red. In Area %	---	---	Weld Time (s)	10
	Hardness	---	---		
	Material	AISI 304/316	AISI 304/316		
ELECTRODE	Shape			Tension Test	
	W = 5/8"			TORSIONNAL	Yield Point
	E = 13/64"				Ultimate
	r = N/A				Mod. Of Rupt.
alpha = N/A			Degree Twist at Ult.		
SPOT	Diameter: 3/16" min.			Shear Load Result	1: 560 Lb
	Overlap or Flange: 0.7" min.				2: 558 Lb
	Spacing: As per drawing				3: 535 Lb
	Roll Speed mm per min. (in. per min.)				4:
Spots per mm (in)			5:		
SEAM	Width of Weld				
	Overlap or Filler			Indentation:	Less than 0.005"
	Length of Weld			Nugget Size:	Over 0.09"
MASH				Other Tests: See lab report M17011208	
	Remarks: Dart Aerospace Ref.: 229 * Clean with alcohol			Photos or sketch 	

Company Lev-Fab Inc.
 Authorized By Denis Martel Ing.

Signature



Denis Martel
 CWI 14110007
 QC1 EXP. 11/1/2017

RESISTANCE WELDING DATA SHEET AND PQR N° RW-2

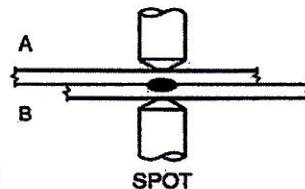
Equipment Identification

Manufacturer: Techno Control

Model: Alpha Series

S/N 3187 Rating 50%

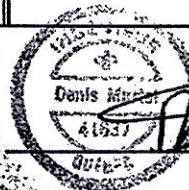
Operator: Frederick Gaudreau



		SIDE A	SIDE B			
MATERIAL	Thickness	0.018"	0.018"	S.C.R.	On	
	Approx. Analysis (type)			Squeeze Time (s)	60	
				Cool Time (s)	0	
	Surface Cond.	Clean *	Clean *	Heat (%)	45	
	Ultimate Strenght	N/A	N/A	Hold Time (s)	6	
	Yield Strenght	N/A	N/A	Off Time (s)	6	
	Elongation %	---	---	Squeeze Force (Psi)	45	
	Red. In Area %	---	---	Weld Time (s)	10	
	Hardness	---	---			
	Material	AISI 304/316	AISI 304/316			
ELECTRODE	Shape			Tension Test		
	W = 5/8"			TORSIONNAL	Yield Point	
	E = 13/64"				Ultimate	
	r = N/A				Mod. Of Rupt.	
	a = N/A			Degree Twist at Ult.		
SPOT	Diameter: 3/16" min.			Shear Load Result	1: 560 Lb	
	Overlap or Flange: 0.7" min.				2: 558 Lb	
	Spacing: As per drawing				3: 535 Lb	
SEAM	Roll Speed mm per min. (in. per min.)				4:	
	Spots per mm (in)				5:	
	Width of Weld					
MASH	Overlap or Filler			Indentation: Less than 0.005"		
	Length of Weld			Nugget Size: Over 0.09"		
				Other Tests: See lab report M17011208		
Remarks: Dart Aerospace Ref.: 229 * Clean with alcohol				Photos or sketch 		

Company Lev-Fab Inc.
 Authorized By Denis Martel Ing.

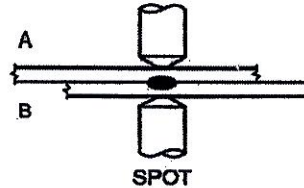
Signature



Denis Martel
 CWI 14110007
 QC1 EXP. 11/1/2017

RESISTANCE WELDING DATA SHEET AND PQR N° RW-2

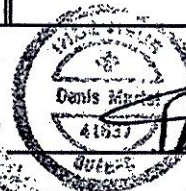
Equipment Identification

Manufacturer: Techno ControlModel: Alpha SeriesS/N 3187 Rating 50%Operator: Frederick Gaudreau

		SIDE A	SIDE B			
MATERIAL	Thickness	0.018"	0.018"	S.C.R.	On	
	Approx. Analysis (type)			Squeeze Time (s)	60	
				Cool Time (s)	0	
	Surface Cond.	Clean *	Clean *	Heat (%)	45	
	Ultimate Strenght	N/A	N/A	Hold Time (s)	6	
	Yield Strenght	N/A	N/A	Off Time (s)	6	
	Elongation %	---	---	Squeeze Force (Psi)	45	
	Red. In Area %	---	---	Weld Time (s)	10	
	Hardness	---	---			
	Material	AISI 304/316	AISI 304/316			
ELECTRODE	Shape			Tension Test		
	W = 5/8"			TORSIONNAL	Yield Point	
	E = 13/64"				Ultimate	
	r = N/A				Mod. Of Rupt.	
alpha = N/A	Degree Twist at Ult.					
SPOT	Diameter: 3/16" min.			Shear Load Result	1: 560 Lb	
	Overlap or Flange: 0.7" min.				2: 558 Lb	
	Spacing: As per drawing				3: 535 Lb	
SEAM	Roll Speed mm per min. (in. per min.)				4:	
	Spots per mm (in)				5:	
	Width of Weld					
MASH	Overlap or Filler			Indentation: Less than 0.005"		
	Length of Weld			Nugget Size: Over 0.09"		
				Other Tests: See lab report M17011203		
Remarks: Dart Aerospace Ref.: 229 * Clean with alcohol				Photos or sketch 		

 Company Lev-Fab Inc.
 Authorized By Denis Martel Ing.

Signature


 Denis Martel
 CWI 14110007
 QC1 EXP. 11/1/2017



GENITEST INC.



LABORATOIRE D'ESSAIS (Métaux, Matériaux) CONSULTATION - RECHERCHE
TESTING LABORATORY (Metals, Materials) CONSULTING - RESEARCH

AEROSPACE LEV-FAB
640 Boul. Mgr Dubois
St-Jérôme, QC
J7Y 3L8

Report Date
Page

January 19, 2017
1 of 2

TEST REPORT EVALUATION OF RESISTANCE SPOT WELDING PROCEDURE CERTIFICATION

M17011208

		Macroscopic and metallographic examination			Acc. Rej.	
Customer #: A001206		Thickness # 1: 0.018"				
Material: Group 2 Weld Class C		Thickness # 2: 0.018"				
Shape: Isolated Spot Weld Sheet Test specimens		W=0.73"; L=3.0"				
Thick. # 1 (sheet): ---		Sample	# 3	# 4		
Thick. # 2 (sheet): ---		Contacting Overlap (<i>min. 0.68"</i>)	0.73"	0.73"	☒	☐
Welder: ---		Edge distance (<i>0.365" ± 0.060"</i>) - 1:	0.375"	0.365"	☒	☐
W/O: ---		-2:	0.355"	0.365"	☒	☐
Testing time: ---		Surface Indentations T1 (<i>max. 0.005"</i>):	0.002"	0.002"	☒	☐
Other: ---		Surface Indentations T2 (<i>max. 0.005"</i>):	0.003"	0.002"	☒	☐
Testing Specifications: AWS D17-2/D17.2M:2013		Penetration T1 - minimum (<i>min 20%T</i>):	51%T (*)	48%T (*)	☒	☐
=====		-maximum (<i>max 90%T</i>):	62%T	59%T	☒	☐
Visual Inspection		Penetration T2 - minimum (<i>min 20%T</i>):	53%T (*)	45%T (*)	☒	☐
ACCEPTED		-maximum (<i>max 90%T</i>):	65%T	53%T	☒	☐
		Sheet separation (<i>max. 0.006"</i>)-Left side:	<0.001"	0.003"	☒	☐
		-Right side	0.003"	<0.001"	☒	☐
		Discontinuities from the edge of the nugget: (<i>Max.: 15% of the nugget radius</i>)	Nil 0.009"	Nil 0.008"	☒	☐
		Discontinuities extending into outer sheet: (<i>Max.: 50% of the sheet thickness</i>)	Nil 0.009"	Nil 0.009"	☒	☐
		The largest discontinuity: (<i>Max.: 25% the nugget diameter</i>)	Nil 0.029"	Nil 0.027"	☒	☐
		Effective weld nugget size (<i>min. 0.090"</i>):	0.116"	0.107"	☒	☐
		Penetration and Annulus Zone (<i>figure 7</i>):	Clear	Clear	☒	☐

ENVIRONMENTAL CONDITIONS DURING TEST

Temperature: 24°C

Pressure: n/a

Relative Humidity: 23%

Comments: **Conforming with AWS D17.2/D17.2M:2013.**

The thickness of the sheets was measured by Genitest.

(*) More than 80% of the measured nugget diameter exceeds the minimum penetration requirement.

See the next page for supplemental information

TEST DONE IN ACCORDANCE WITH MCLM FC-23 E and BAERD-GEN-018E

ALL INSTRUMENTS ARE CALIBRATED USING STANDARDS AND MEASURING DEVICES TRACEABLE TO NIST (NBS). TECHNICAL PROCEDURES AND SPECIFICATIONS RELATIVE TO Nadcap QUALITY STANDARDS HAVE BEEN FOLLOWED FOR THIS REPORT.

Liability: Genitest Testing's liability to the client or any third party is limited to the amount charged for services provided.

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Subcontractor: NIL

Document #GT-WF311-02

Jean Lavoie, PE Metallurgist



GENITEST INC.



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TEST REPORT EVALUATION OF RESISTANCE SPOT WELDING PROCEDURE CERTIFICATION

M17011208

		Macroscopic and metallographic examination			
		Sample	# 3	# 4	Acc. Rej.
Customer #: A001206 Material: Group 2 Weld Class C Shape: Isolated Spot Weld Sheet Test specimens Thick. # 1 (sheet): --- Thick. # 2 (sheet): --- Welder: --- W/O: --- Testing time: --- Other: --- Testing Specifications: AWS D17-2/D17.2M:2013 ===== Visual Inspection ACCEPTED	Thickness # 1: 0.018"				
	Thickness # 2: 0.018"				
	W=0.73"; L=3.0"				
	Contacting Overlap (min. 0.68")	0.73"	0.73"	☒	☐
	Edge distance (0.365" ± 0.060") - 1:	0.375"	0.365"	☒	☐
	- 2:	0.355"	0.365"	☒	☐
	Surface Indentations T1 (max. 0.005"):	0.002"	0.002"	☒	☐
	Surface Indentations T2 (max. 0.005"):	0.003"	0.002"	☒	☐
	Penetration T1 - minimum (min 20% T):	51% T (*)	48% T (*)	☒	☐
	- maximum (max 90% T):	62% T	59% T		
	Penetration T2 - minimum (min 20% T):	53% T (*)	45% T (*)	☒	☐
	- maximum (max 90% T):	65% T	53% T		
	Sheet separation (max. 0.006") - Left side:	<0.001"	0.003"	☒	☐
	- Right side:	0.003"	<0.001"		
	Discontinuities from the edge of the nugget: (Max. : 15% of the nugget radius)	Nil 0.009"	Nil 0.008"	☒	☐
Discontinuities extending into outer sheet: (Max.: 50% of the sheet thickness)	Nil 0.009"	Nil 0.009"	☒	☐	
The largest discontinuity: (Max.: 25% the nugget diameter)	Nil 0.029"	Nil 0.027"	☒	☐	
Effective weld nugget size (min. 0.090"):	0.116"	0.107"	☒	☐	
Penetration and Annulus Zone (figure 7):	Clear	Clear	☒	☐	

ENVIRONMENTAL CONDITIONS DURING TEST

Temperature: 24°C

Pressure: n/a

Relative Humidity: 23%

Comments: **Conforming with AWS D17.2/D17.2M:2013.**

The thickness of the sheets was measured by Genitest.

(*) More than 80% of the measured nugget diameter exceeds the minimum penetration requirement.

See the next page for supplemental information

TEST DONE IN ACCORDANCE WITH MCLM FC-23 E and BAERD-GEN-018E

ALL INSTRUMENTS ARE CALIBRATED USING STANDARDS AND MEASURING DEVICES TRACEABLE TO NIST (NBS). TECHNICAL PROCEDURES AND SPECIFICATIONS RELATIVE TO Nadcap QUALITY STANDARDS HAVE BEEN FOLLOWED FOR THIS REPORT.

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Jean Lavoie, PE Metallurgist



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TEST REPORT EVALUATION OF RESISTANCE SPOT WELDING PROCEDURE CERTIFICATION

M17011208

		Macroscopic and metallographic examination			
		Sample	# 3	# 4	Acc. Rej.
Customer #: A001206 Material: Group 2 Weld Class C Shape: Isolated Spot Weld Sheet Test specimens Thick. # 1 (sheet): --- Thick. # 2 (sheet): --- Welder: --- W/O: --- Testing time: --- Other: --- Testing Specifications: AWS D17-2/D17.2M:2013 Visual Inspection ACCEPTED	Thickness # 1: 0.018"				
	Thickness # 2: 0.018"				
	W=0.73"; L=3.0"				
	Contacting Overlap (<i>min. 0.68"</i>)	0.73"	0.73"	☒	☐
	Edge distance (<i>0.365" ± 0.060"</i>) - 1:	0.375"	0.365"	☒	☐
	- 2:	0.355"	0.365"	☒	☐
	Surface Indentations T1 (<i>max. 0.005"</i>):	0.002"	0.002"	☒	☐
	Surface Indentations T2 (<i>max. 0.005"</i>):	0.003"	0.002"	☒	☐
	Penetration T1 - minimum (<i>min 20% T</i>):	51% T (*)	48% T (*)	☒	☐
	- maximum (<i>max 90% T</i>):	62% T	59% T		
	Penetration T2 - minimum (<i>min 20% T</i>):	53% T (*)	45% T (*)	☒	☐
	- maximum (<i>max 90% T</i>):	65% T	53% T		
	Sheet separation (<i>max. 0.006"</i>) - Left side:	<0.001"	0.003"	☒	☐
	- Right side:	0.003"	<0.001"		
	Discontinuities from the edge of the nugget: (<i>Max. : 15% of the nugget radius</i>)	Nil 0.009"	Nil 0.008"	☒	☐
Discontinuities extending into outer sheet: (<i>Max.: 50% of the sheet thickness</i>)	Nil 0.009"	Nil 0.009"	☒	☐	
The largest discontinuity: (<i>Max.: 25% the nugget diameter</i>)	Nil 0.029"	Nil 0.027"	☒	☐	
Effective weld nugget size (<i>min. 0.090"</i>):	0.116"	0.107"	☒	☐	
Penetration and Annulus Zone (<i>figure 7</i>):	Clear	Clear	☒	☐	

ENVIRONMENTAL CONDITIONS DURING TEST

Temperature: 24°C

Pressure: n/a

Relative Humidity: 23%

Comments: Conforming with AWS D17.2/D17.2M:2013.

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Subcontractor: NIL

Document #GT-WF311-02

Jean Lavoie, PE Metallurgist

Supplemental Information

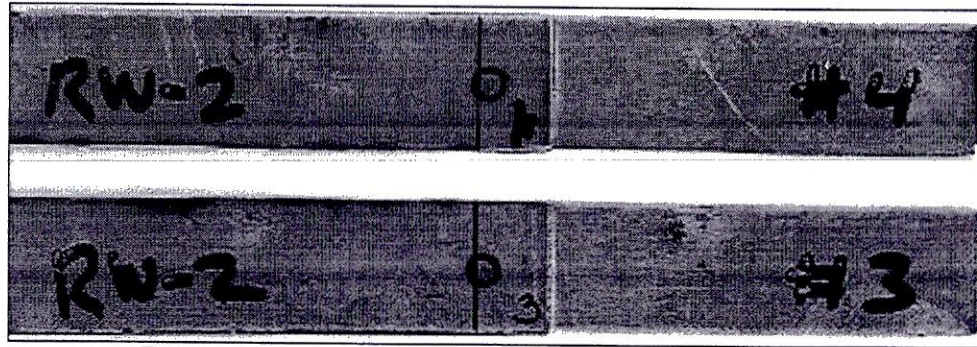


Figure 1 – Specimens as received for metallographic evaluation

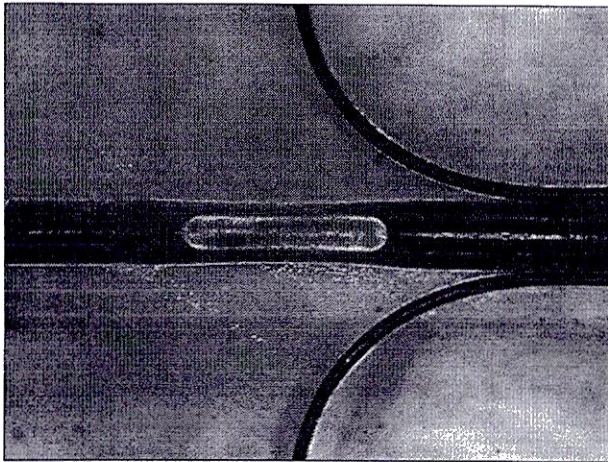


Figure 2 – Transverse section through the mid of the spot weld no 3 – Etchant: Vilella's - Magnification 10x 1 mm

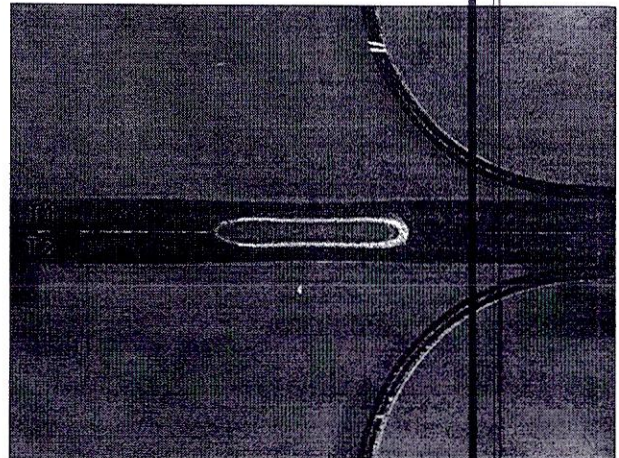


Figure 3 – Transverse section through the mid of the spot weld no 4 – Etchant: Vilella's - Magnification 10x 1 mm

Supplemental Information

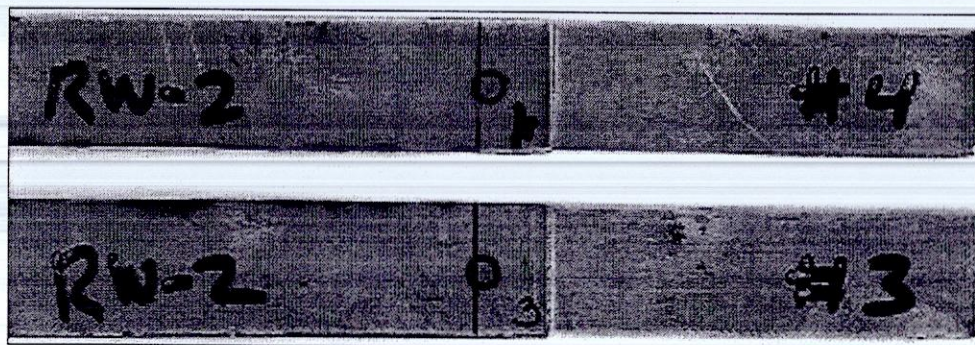


Figure 1 – Specimens as received for metallographic evaluation

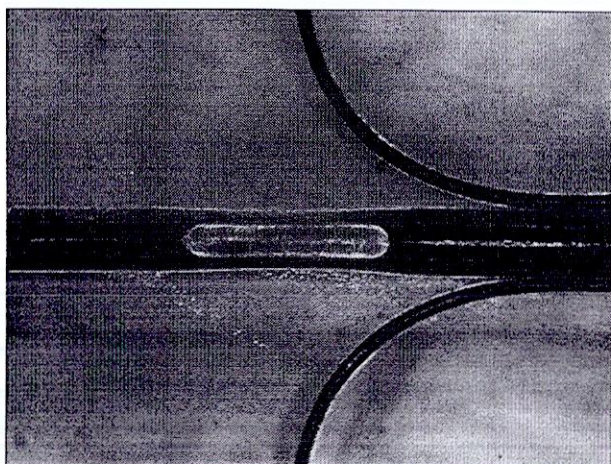


Figure 2 – Transverse section through the mid of the spot weld no 3 – Etchant: Vilella's - Magnification 10x [1 mm]

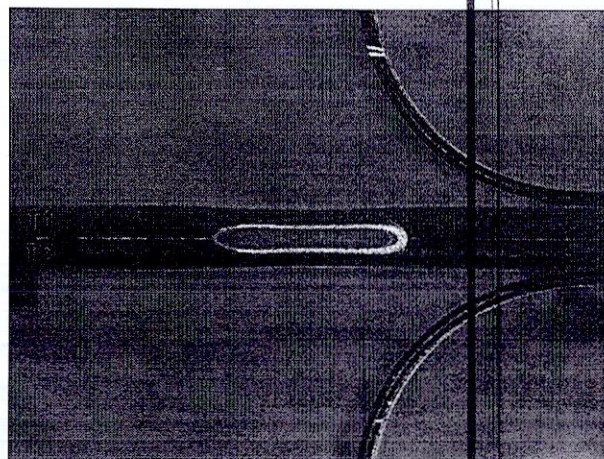


Figure 3 – Transverse section through the mid of the spot weld no 4 – Etchant: Vilella's - Magnification 10x [1 mm]



Supplemental Information

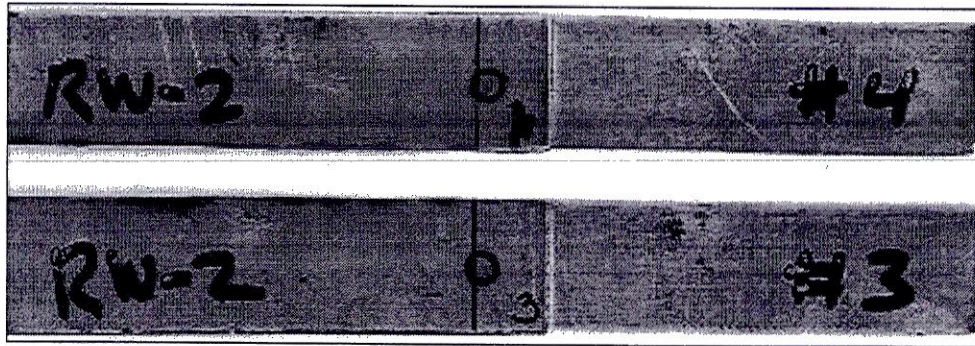


Figure 1 – Specimens as received for metallographic evaluation

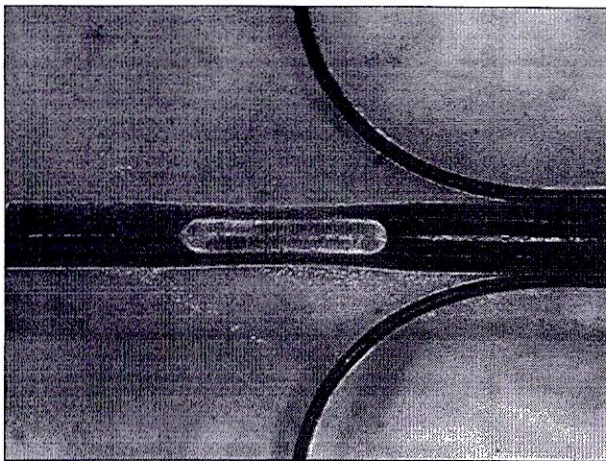


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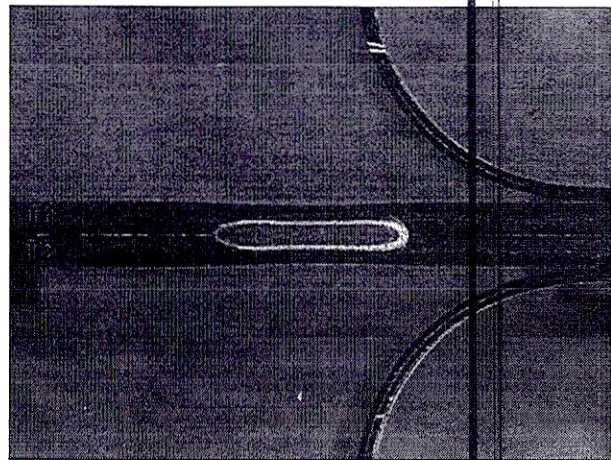


Figure 3 – Transverse section through the mid of the spot weld no 4 – Etchant: Vilella's - Magnification 10x 1 mm





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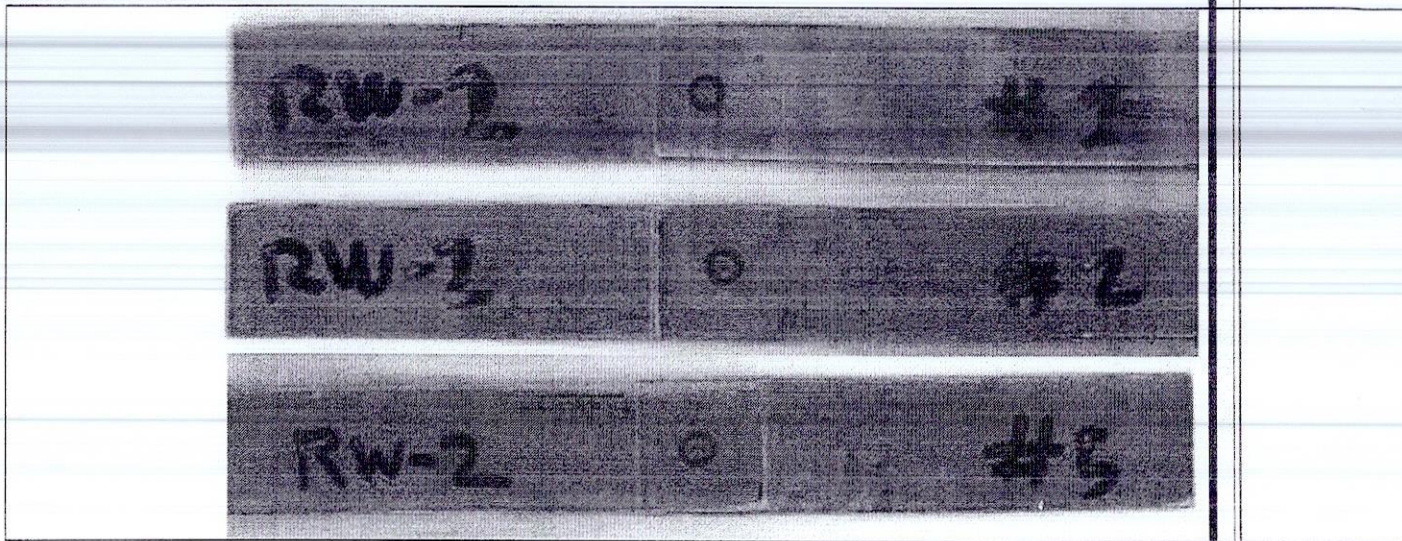
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TEST REPORT SHEAR TEST

L17011208



Customer #: A001206	Sample #:	LOAD
Specification: AWS D17-2		(lb _f)
Material: ---	1	560
Shape: Shear test sample	2	558
Dimensions: 0.018" thick.	5	535
Testing Spec.: ASTM E8-15	Average	551

ENVIRONMENTAL CONDITIONS DURING TEST
Comments:

Temperature: 21°C

Pressure: n/a

Relative Humidity: 24%

TEST DONE IN ACCORDANCE WITH MCLM F-23C and BAERD-GEN-018E

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TECHNICAL PROCEDURES AND SPECIFICATIONS RELATIVE TO Nadcap AND ISO/IEC 17025 QUALITY STANDARDS HAVE BEEN FOLLOWED FOR THIS REPORT.

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Subcontractor: NIL

Document #GT-ED311-02

Jean Lavoie, PE Metallurgist



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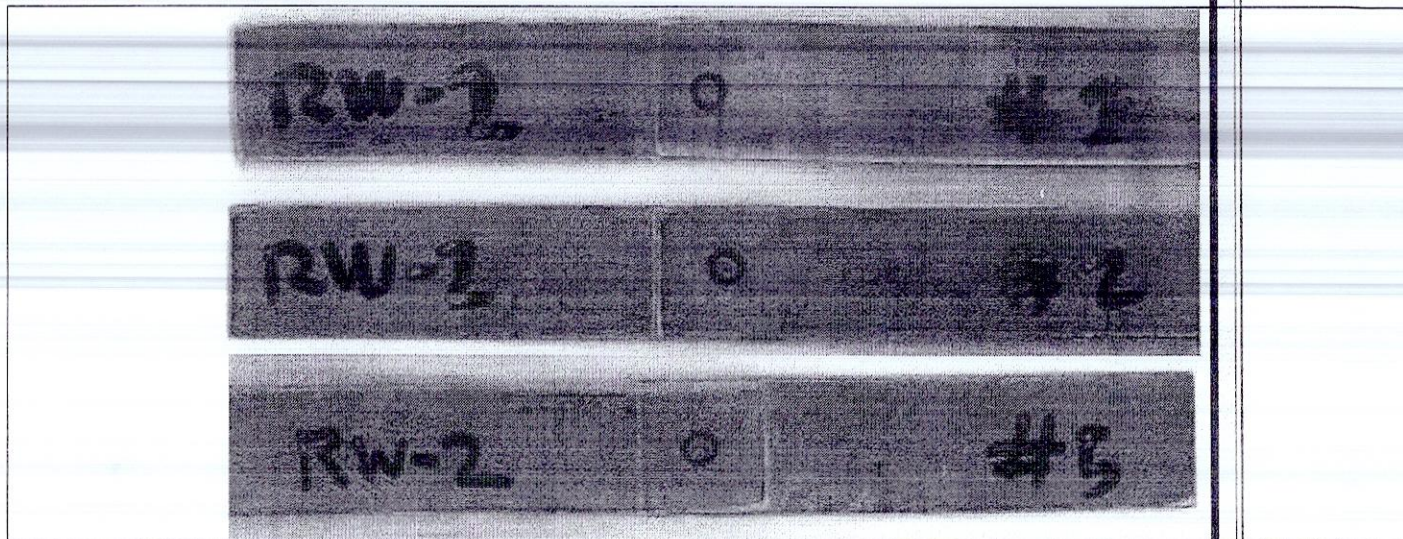
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Comments:

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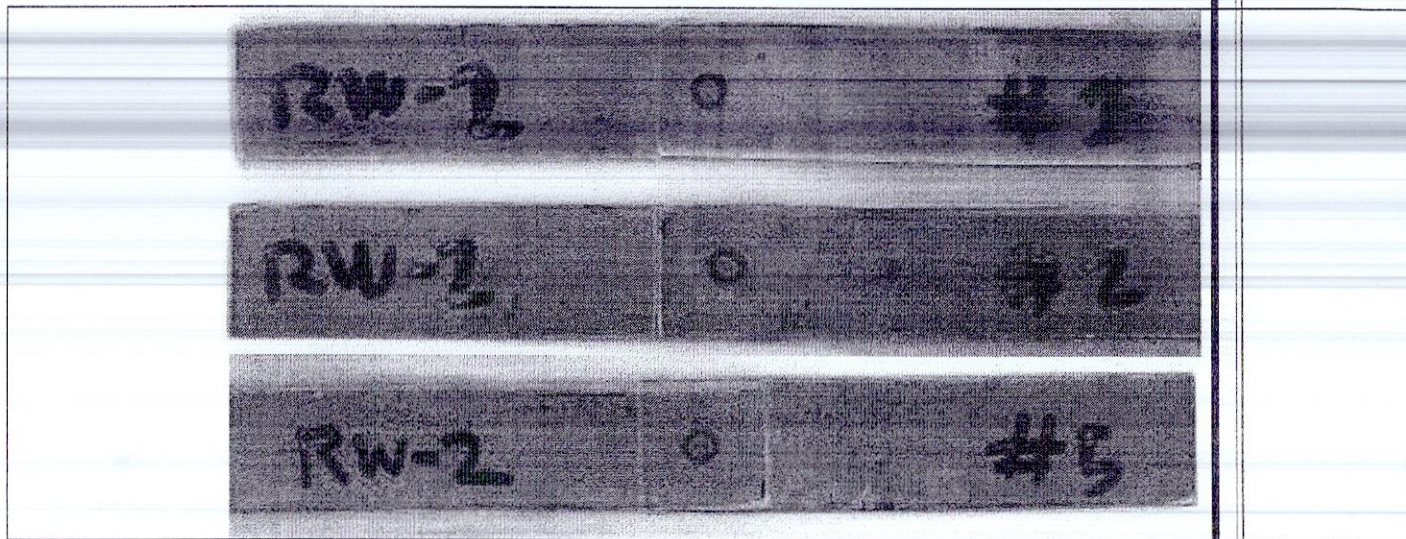
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Subcontractor: NIL

Document #GT-ED311-02

Jean Lavoie, PE Metallurgist



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO34695

Purchase Order Date 12/20/2016

PO Print Date 12/20/2016

Page Number 1 of 2

Order From :
AEROSPACE LEV-FAB
640 BOUL. MGR. DUBOIS
ST JEROME, QUEBEC J7Y 3L8

VC-ALF01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 514-876-8787

Ship To Contact

Ship To Phone

Ship Via: FedEx Economy collect

Ship Acct:

Buyer

Linda Lacelle

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	154263	D3480-041	1/10/2017 No 1/10/2017		2.00	\$0.00	\$0.00
	spot weld per drwg and QSI005						
Line Total:							\$0.00
2	154262	D3480-043	1/10/2017 No 1/10/2017		2.00	\$0.00	\$0.00
	spot weld per drwg and QSI005						
Line Total:							\$0.00
3	154264	D3479-041	1/10/2017 No 1/10/2017		2.00	\$0.00	\$0.00
	spot weld per drwg and QSI005						

PO Instructions: Fedex Acct # 151793240

Note:

12/20/2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34695**

Purchase Order Date 12/20/2016

PO Print Date 12/20/2016

Page Number 1 of 2

Order From :
AEROSPACE LEV-FAB
640 BOUL. MGR. DUBOIS
ST JEROME, QUEBEC J7Y 3L8

VC-ALF01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 514-876-8787

Buyer

Linda Lacelle

Customer POID

Customer Tax # 10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

FedEx Economy collect

FOB

Destination-Collect

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	154263	D3480-041	1/10/2017 No 1/10/2017		2.00	\$0.00	\$0.00
	spot weld per drwg and QSI005						
						Line Total:	\$0.00
2	154262	D3480-043	1/10/2017 No 1/10/2017		2.00	\$0.00	\$0.00
	spot weld per drwg and QSI005						
						Line Total:	\$0.00
3	154264	D3479-041	1/10/2017 No 1/10/2017		2.00	\$0.00	\$0.00
	spot weld per drwg and QSI005						

PO Instructions: Fedex Acct # 151793240

Note:

12/20/2016



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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
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Fax: 613 632 1053

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VC-ALF01

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640 BOUL. MGR. DUBOIS
ST JEROME, QUEBEC J7Y 3L8

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

514-876-8787

Buyer

Linda Lacelle

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Ship To Phone

Ship Via:

FedEx Economy collect

Ship Acct:

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Net 30

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Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	154263	D3480-041	1/10/2017 No 1/10/2017		2.00	\$0.00	\$0.00
	spot weld per drwg and QSI005						
Line Total:							\$0.00
2	154262	D3480-043	1/10/2017 No 1/10/2017		2.00	\$0.00	\$0.00
	spot weld per drwg and QSI005						
Line Total:							\$0.00
3	154264	D3479-041	1/10/2017 No 1/10/2017		2.00	\$0.00	\$0.00
	spot weld per drwg and QSI005						

PO Instructions: Fedex Acct # 151793240

Note:

12/20/2016



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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

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Purchase Order ID PO14695

Purchase Order Date 12/20/2016

PO Print Date 12/20/2016

Page Number 2 of

Order From :

VC-ALF01

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640 BOUL. MGR. DUBOIS
ST JEROME, QUEBEC J7Y 3L8

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 514 876-8787

Ship To Contact

Ship To Phone

Ship Via: FedEx Economy collect

Ship Acct:

Buyer

Linda Lacelle

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: \$0.00

Line	Item	Description	Quantity	Unit Price	Total Price
4	71401-45	PROCUREMENT QUALITY CLAUSE	1.00	\$0.00	\$0.00

No

1/10/2017

Procurement Quality Clauses

A004 faa-pma/tso

A005 right of entry

A008 first article inspection (FAI documentation maintained by seller Documentation sent to Dart Aerospace)

A016 personnel qualification

A026 certification of materila conformance

A040 notification of escape clauses

A042 dart notification by supplier

A043 retention of quality document

Line Total: \$0.00

5	71401-45	FAI - 2 samples B154684	1.00	\$0.00	\$0.00
---	----------	-------------------------	------	--------	--------

No

1/10/2017

Line Total: \$0.00

PO Total: \$0.00

PO Instructions: Fedex Acct # 151793240

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 12/20/2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14695

Purchase Order Date 12/20/2016

PO Print Date 12/20/2016

Page Number 2 of 2

Order From :

VC-ALF01

AEROSPACE LEV-FAB
640 BOUL. MGR. DUBOIS
ST JEROME, QUEBEC J7Y 3L8

Ship To :

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

514-876-8787

Buyer

Linda Lacelle

Customer POID

Customer Tax # 10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

FedEx Economy collect

FOB

Destination-Collect

Ship Acct:

Line Total: \$0.00

Line	Part Number	Description	Quantity	Unit Price	Total Price
4	71401-45	PROCUREMENT QUALITY CLAUSE	1.00	\$0.00	\$0.00

No

1/10/2017

Procurement Quality Clauses

A004 faa-pma/tso

A005 right of entry

A008 first article inspection (FAI documentation maintained by seller Documentation sent to Dart Aerospace)

A016 personnel qualification

A026 certification of materila conformance

A040 notification of escape clauses

A042 dart notification by supplier

A043 retention of quality document

Line Total: \$0.00

Line	Part Number	Description	Quantity	Unit Price	Total Price
5	71401-45	FAI - 2 samples B154684	2.00	\$0.00	\$0.00

No

1/10/2017

Line Total: \$0.00

PO Total: \$0.00

PO Instructions: Fedex Acct # 151793240

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Change Nbr: 1

Change Date: 12/20/2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14695

Purchase Order Date 12/20/2016

PO Print Date 12/20/2016

Page Number 2 of 2

Order From :

VC-ALF01

AEROSPACE LEV-FAB
640 BOUL. MGR. DUBOIS
ST JEROME, QUEBEC J7Y 3L8

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 514 876-8787

Buyer

Linda Lacelle

Customer POID

Customer Tax # 10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

FedEx Economy collect

FOB

Destination-Collect

Ship Acct:

Line Total: \$0.00

4	71401-45	PROCUREMENT QUALITY CLAUSE	1/10/2017	1.00	\$0.00	\$0.00
---	----------	-------------------------------	-----------	------	--------	--------

No

1/10/2017

Procurement Quality Clauses

A004 faa-pma/tso

A005 right of entry

A008 first article inspection (FAI documentation maintained by
seller Documentation sent to Dart Aerospace)

A016 personnel qualification

A026 certification of materila conformance

A040 notification of escape clauses

A042 dart notification by supplier

A043 retention of quality document

Line Total: \$0.00

5	71401-45	FAI - 2 samples B154684	1/10/2017	2.00	\$0.00	\$0.00
---	----------	-------------------------	-----------	------	--------	--------

No

1/10/2017

Line Total: \$0.00

PO Total: \$0.00

PO Instructions: Fedex Acct # 151793240

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 12/20/2016

DART AEROSPACE LTD

QUALITY SYSTEM INSTRUCTION: QSI 018

***TITLE:* Standard Tolerances**

***ISSUE:* 03**

***DATE:* November 30, 2004**

PREPARED BY: David Shepherd

REVIEWED

**Linda Lacelle
PRODUCTION MANAGER**

**David Shepherd
CHIEF ENGINEER**

**Bill Beckett
DESIGN MANAGER**

APPROVED BY:

**Susanne Sheldon
DIRECTOR, QUALITY ASSURANCE**

DART AEROSPACE LTD

QUALITY SYSTEM INSTRUCTION: QSI 018

TITLE: **Standard Tolerances**

ISSUE: **03**

DATE: **November 30, 2004**

PREPARED BY: **David Shepherd**

REVIEWED

Linda Lacelle
PRODUCTION MANAGER

David Shepherd
CHIEF ENGINEER

Bill Beckett
DESIGN MANAGER

APPROVED BY:

Susanne Sheldon
DIRECTOR, QUALITY ASSURANCE

DART AEROSPACE LTD

QUALITY SYSTEM INSTRUCTION: QSI 018

TITLE: Standard Tolerances

ISSUE: 03

DATE: November 30, 2004

PREPARED BY: David Shepherd

REVIEWED

**Linda Lacelle
PRODUCTION MANAGER**

**David Shepherd
CHIEF ENGINEER**

**Bill Beckett
DESIGN MANAGER**

APPROVED BY:

**Susanne Sheldon
DIRECTOR, QUALITY ASSURANCE**

STANDARD TOLERANCES

Procedure Issue Date: 04.11.30 Issue No: 03

1.0 PURPOSE

To establish the tolerances for DART production

2.0 SCOPE

This work instruction applies to all parts manufactured, or designed by DART, unless otherwise stated on a drawing

3.0 RESPONSIBILITY**3.1 PRODUCTION MANAGER**

Has the responsibility of ensuring the tolerances are being followed

3.2 DIRECTOR, QUALITY ASSURANCE

Is responsible for auditing that the tolerances are being followed.

4.0 PROCEDURE**4.1** Follow the following requirements (unless otherwise stated):

1. Dimensions are in inches.
2. Surface roughness 125✓. (Visual inspection accepted).
3. Remove sharp edges .015 max.
4. Threads per MIL-S-7742
5. Holes per the following table: (source: AND10387)

Hole Diameter	Tolerance
0.0135 to 0.125	+ 0.004 / - 0.001
0.126 to 0.250	+ 0.005 / - 0.001
0.251 to 0.500	+ 0.006 / - 0.001
0.501 to 0.750	+ 0.008 / - 0.001
0.751 to 1.000	+ 0.010 / - 0.001
1.001 to 2.000	+ 0.012 / - 0.001

6. Dimensions:

X.X	+/- 0.100
X.XX	+/- 0.030
X.XXX	+/- 0.010
7. Angles

	+/- 1/2°
--	----------
8. Parallelism

	+/- 0.0025
--	------------
9. Eccentricity

	0.005 Max
--	-----------
10. Symmetry about all M/C center lines

	0.005
--	-------

STANDARD TOLERANCES

Procedure Issue Date: 04.11.30 Issue No: 03

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8. Parallelism

	+/- 0.0025
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	0.005
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STANDARD TOLERANCES

Procedure Issue Date: 04.11.30 Issue No: 03

1.0 PURPOSE

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	+/- 1/2°
--	----------
8. Parallelism

	+/- 0.0025
--	------------
9. Eccentricity

	0.005 Max
--	-----------
10. Symmetry about all M/C center lines

	0.005
--	-------

STANDARD TOLERANCES

Procedure Issue Date: 04.11.30 Issue No: 03

REVISION RECORD: B

PAGE	PAGE REV.	SUBJECT	DATE	INITIAL	DQA
1	A	No change			
2	B	Revised issue page	06.08.03		
3	B	Revised Section 4.1	06.08.03		

STANDARD TOLERANCES

Procedure Issue Date: 04.11.30 Issue No: 03

REVISION RECORD: B

PAGE	PAGE REV.	SUBJECT	DATE	INITIAL	DQA
1	A	No change			
2	B	Revised issue page	06.08.03		
3	B	Revised Section 4.1	06.08.03		

STANDARD TOLERANCES

Procedure Issue Date: 04.11.30 Issue No: 03

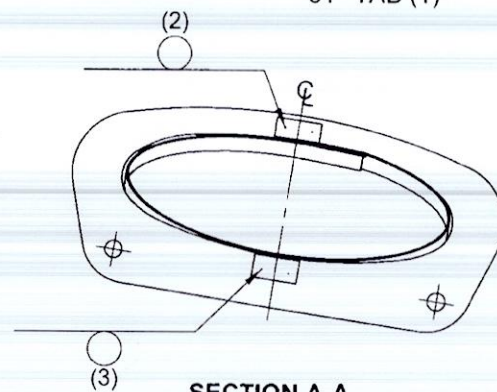
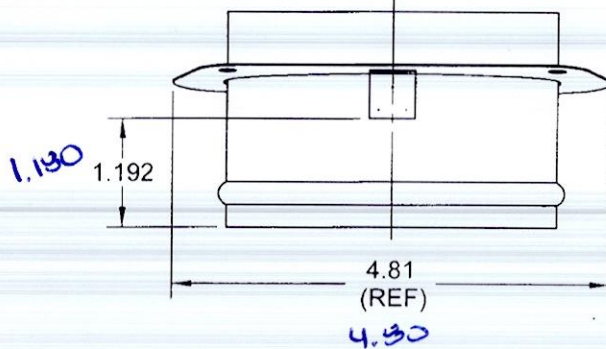
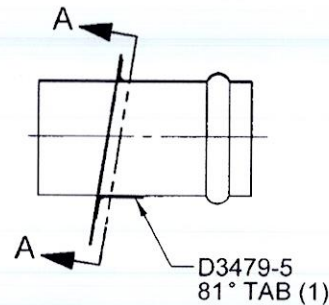
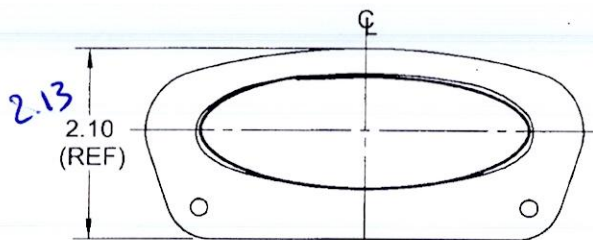
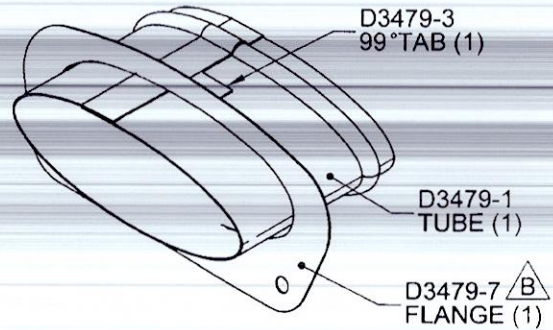
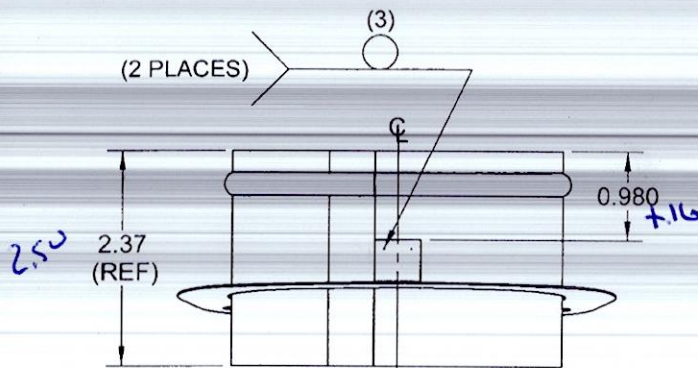
REVISION RECORD: B

PAGE	PAGE REV.	SUBJECT	DATE	INITIAL	DQA
1	A	No change			
2	B	Revised issue page	06.08.03		
3	B	Revised Section 4.1	06.08.03		



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. B SHEET 1 OF 4
DATE 08.12.19		TITLE INLET ADAPTER	SCALE 1:2
A	06.01.19	NEW ISSUE	
B	08.12.19	CORRECT TYPO ON SHT1; ADD TOL ON SHT2; MATL SPEC WAS MIL-S-5019	

RELEASED
01/01/30 M



D3479-041 INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 018
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

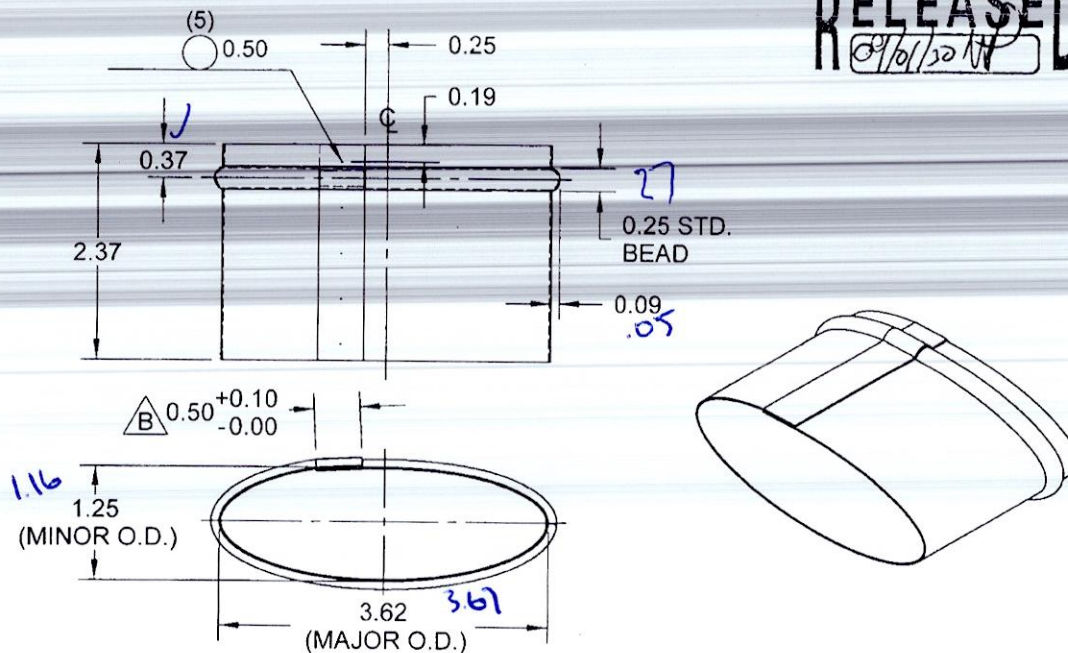
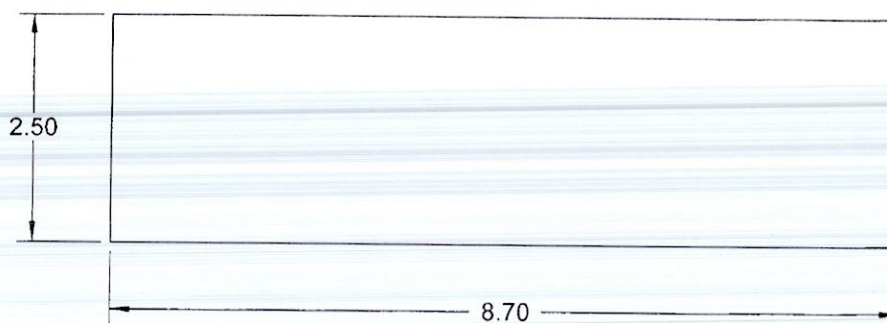
QTY -041	P/N	DESCRIPTION
X	D3479-041	INLET ADAPTER
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. B SHEET 2 OF 4
DATE 08.12.19		TITLE INLET ADAPTER	SCALE 1:2

RELEASED
07/01/2019**D3479-1 TUBE****D3479-1F FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI.018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

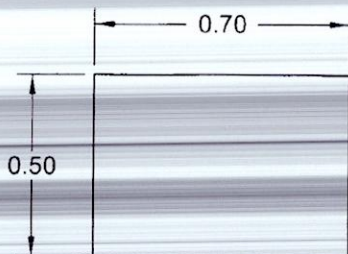
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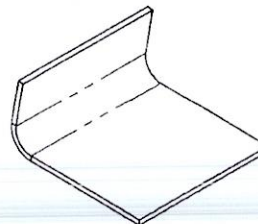
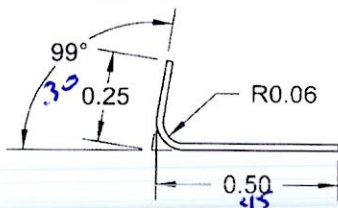
DESIGN b	DRAWN BY b	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RH	APPROVED #	DRAWING NO. D3479	REV. B SHEET 3 OF 4
DATE 08.12.19		TITLE ADAPTER INLET	SCALE 2:1

RELEASED
09/01/30 MWD

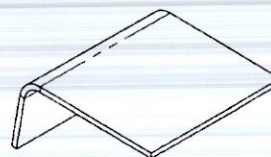
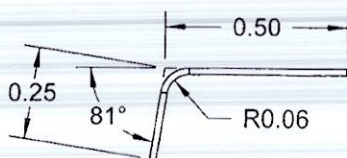


D3479-3F FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)



D3479-3 99 DEGREE TAB (MAKE FROM D3479-3F FLAT PATTERN)



D3479-5 81 DEGREE TAB (MAKE FROM D3479-3F FLAT PATTERN)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

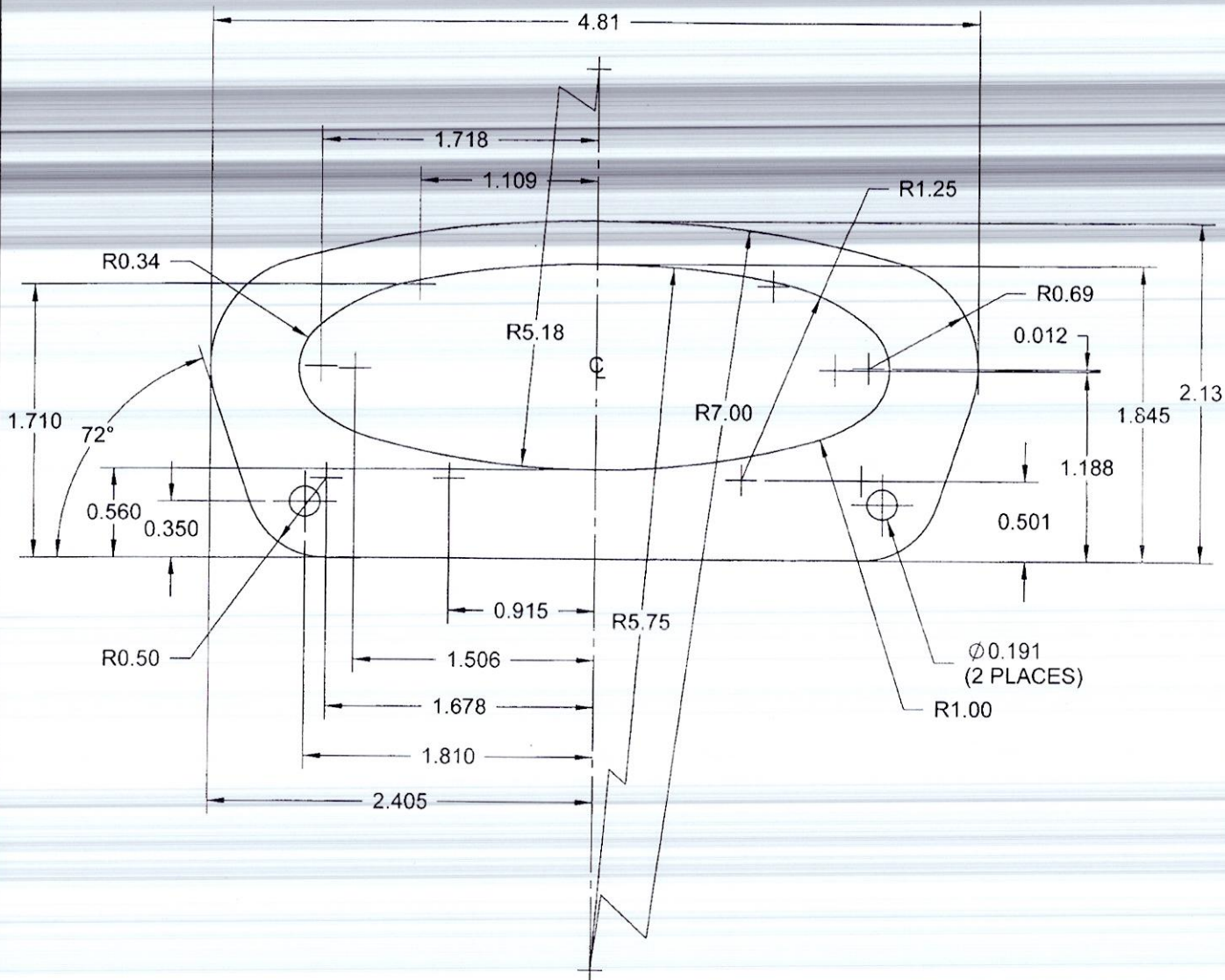
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. B SHEET 4 OF 4
DATE 08.12.19	TITLE ADAPTER INLET		SCALE 1:1

RELEASED
9/6/30 NM



D3479-7 FLANGE PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle_B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Page 1 of 1

All amounts are calculated in domestic currency.

All Vendors PO ID PO34695 All Receipt Dates All Line Item Types
All Item ID/GL/WCs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty/ (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-ROY001	RBC Royal Bank - Visa								
PO34695	1		154263		1/27/2017	1/27/2017	2.0000	\$134.03	0.0000	0	\$268.06
CAD	No		D3480-041 M136718		2.0000	QUIR01		\$268.06	0.0000	0	
	2		154262		1/27/2017	1/27/2017	2.0000	\$134.03	0.0000	0	\$268.06
	No		D3480-043 M136718		2.0000	QUIR01		\$268.06	0.0000	0	
	3		154264		1/27/2017	1/27/2017	2.0000	\$134.03	0.0000	0	\$268.06
	No		D3479-041 M136718		2.0000	QUIR01		\$268.06	0.0000	0	
	4		71401-45		1/27/2017	1/27/2017	1.0000	\$0.00	0.0000	0	\$0.00
	No		PROCUREMENT QUALITY CLAUSE M136718		1.0000	QUIR01		\$0.00	0.0000	0	
	5		71401-45		1/27/2017	1/27/2017	2.0000	\$134.03	0.0000	0	\$268.06
	No		FAI - 2 samples B154684 M136718		2.0000	QUIR01		\$268.06	0.0000	0	
Total Received Quantity:											9.0000
Total Qty to Inspect (PO U/M):											0.0000
Total Reject Quantity:											0.0000
Total Receipt Value:											\$1,072.23
Total Balance Due Quantity:											0.0000



AEROSPACE
LEV-FAB

640 Monseigneur-Dubois Blvd.
St-Jerome, Qc, Canada, J7Y 3L8
Phone: 450-438-7164
Fax: 450-438-9846
www.lev-fab.com



Canada
Controlled Goods program
Programme des marchandises contrôlées

Packing slip

315

Shipped on Feb 17, 2017

Page 1/1

Ship to

DART AEROSPACE
1270 Aberdeen Street
Hawkesbury, Ontario, Canada
K6A 1K7

Customer

1521

DART AEROSPACE
1270 Aberdeen Street
Hawkesbury, Ontario, Canada
K6A 1K7

Contact: Linda Lacelle

Tel: 1 613 632-9577

Fax:

Courriel:

Contact: Linda Lacelle

Tel: 1 613 632-9577 x. 235

Fax:

Courriel: llacelle@dartaero.com

Order date	Payment terms	Customer PO	Order no.	FOB	Freight charges
Dec 20, 2016	C.O.D. 1 ERE COMMANDE	PO34695	229	Origine	Collect

Line	Item	Rev.	Ref. no.	On order	Ship. qty	Back order	PKG
3	D3479-041 EYEBALL ADAPTER	B		2 UN	2	0	

Packed by	Date	Name	Carrier name	Pieces	Total
		APOLLO BOUC	VOTRE TRANSPOR		



AÉRONAUTIQUE
LEV-FAB

640, boul. Mgr Dubois
Saint-Jérôme (Québec) J7Y 3L8
Téléphone : 450 438-7164
Télécopieur : 418 438-9846
www.lev-fab.com

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

CLIENT / CUSTOMER		# ORDRE D'ACHAT / PURCHASE ORDER		DATE	
DART AEROSPACE		PO34695		2017-02-17	
# DE LA PIÈCE / PART #		NOM DE LA PIÈCE / PART NAME			# DE SÉRIE / SERIAL NUMBER
D3479-041		INLET ADAPTER			N/A
# DESSIN / DRAWING #		REV. DESSIN / DRAWING REV.		CHANGEMENT ADDITIONNEL / ADDITIONAL CHANGE	
D3479		B		N/A	
QUANTITÉ / QUANTITY		# BON DE TRAVAIL / WORK ORDER#		# DE CERTIFICAT / CERTIFICATE #	
2		625-1		625-1	
ADRESSE DE LIVRAISON / SHIPPING ADDRESS					
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 CANADA					
INDEX DES PIÈCES, OPÉRATIONS, INSPECTION POUR RÉALISER SOUS-ASSEMBLAGE OU L'ASSEMBLAGE IDENTIFIÉ PLUS HAUT. INDEX OF PARTS, OPERATIONS, INSPECTION TO CARRY OUT SUBASSEMBLY OR ASSEMBLY IDENTIFIED ABOVE.					
MATIÈRE PREMIÈRE / TRAITEMENT / OPERATION RAW MATERIAL / PROCESS / OPERATIONS		DISTRIBUTEUR / DISTRIBUTOR		RÉSULTAT / # CERTIFICAT RESULT / CERTIFICATE #	
Matière première se référer à l'ordre d'achat Raw material refer to PL D3479 FROM DART AEROSPACE (PART LIST): - D3479-1: TUBE - D3479-3: 99 DEGREE TAB - D3479-2: 81 DEGREE TAB - D3479-7: FLANGE		DART AEROSPACE		COMPLETED	
Méthodes / Processes : - Processes: Manufacture as per Drawing Requirement or per attached Notification Requirement, if applicable. - Spot weld per QSI004 - Protect for shipment.		LEV-FAB LEV-FAB LEV-FAB		COMPLETED see waiver 2017-02-15 COMPLETED COMPLETED	
Contrôle Non-Destructif / NDT inspection		N/A		N/A	
Inspection premier article / First article inspection		LEV-FAB		COMPLETED	
Je certifie par la présente que l'article énuméré ci-dessus est conforme, après inspection et essai, aux dessins et aux spécifications indiqués ou cités sur votre bon de commande. I hereby certify, that above article has been inspected and tested and conforms to the drawings and/or specification quoted on, or referenced by your Purchase Order.					
Signature				Date 2017-02-17	



E-CC (Avril 2016)



ISO 9001



AS 9100



Accredited
Nadcap

Canada

Controlled Goods program
Programme des marchandises contrôlées

GRUPE



PCE/PART : D3479-041 REV. :B
P.O.# : PO34695 QTÉ : 2
CONTRAT# : 229
CONTACT : Eric Downing

DEROGATION / DEVIATION (WAIVER/DEVIATION)

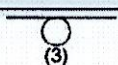
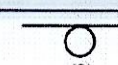
DATE : 2017-02-15

CLIENT : DART AEROSPACE

ACHETEUR (PURCHASER) : Linda Lascelle

SPÉC. ORIGINALE (ORIGINAL SPEC.)

DÉROGATION/DÉVIATION (WAIVER/DEVIATION)

A) 2.37 (REF)	A) 2.50 CUSTOMER MATERIAL
B) 	B)  MISSING SPACE

DECISION

Utiliser tel quel (Use As) ☒

Avis de changement (Notice of Change) ☐

Accepté (Accepted) ☐

Demande refusée (Request Denied) ☐

Signature : 

Date : 2017/02/16

Réparation des pièces (Repair Parts) ☐

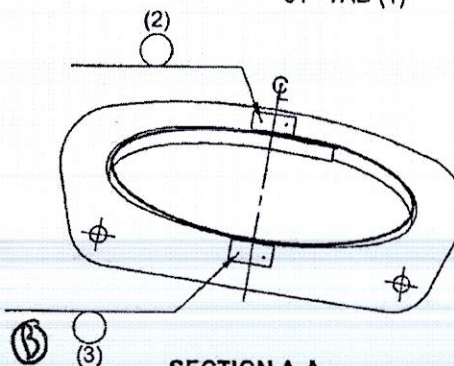
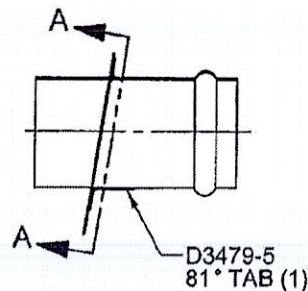
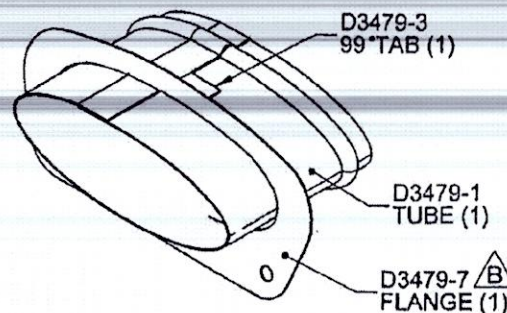
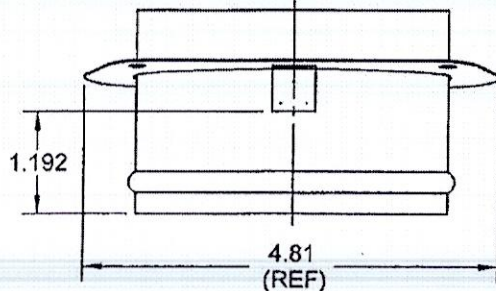
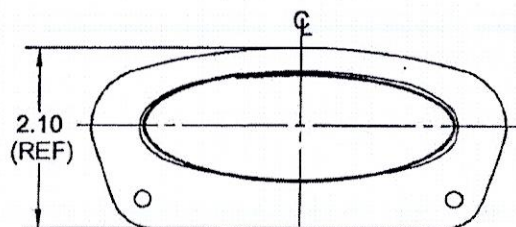
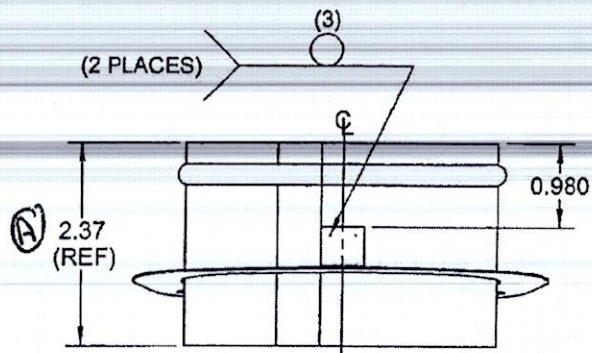
Fournir pièces au dessin (Provide Parts to Drawing) ☐

Signature :

Date :

DART**RELEASED**
01/01/30 M

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED M	DRAWING NO. D3479	REV. B SHEET 1 OF 4
DATE 08.12.19		TITLE INLET ADAPTER	SCALE 1:2
A	06.01.19	NEW ISSUE	
B	08.12.19	CORRECT TYPO ON SHT1; ADD TOL ON SHT2; MATL SPEC WAS MIL-S-5019	

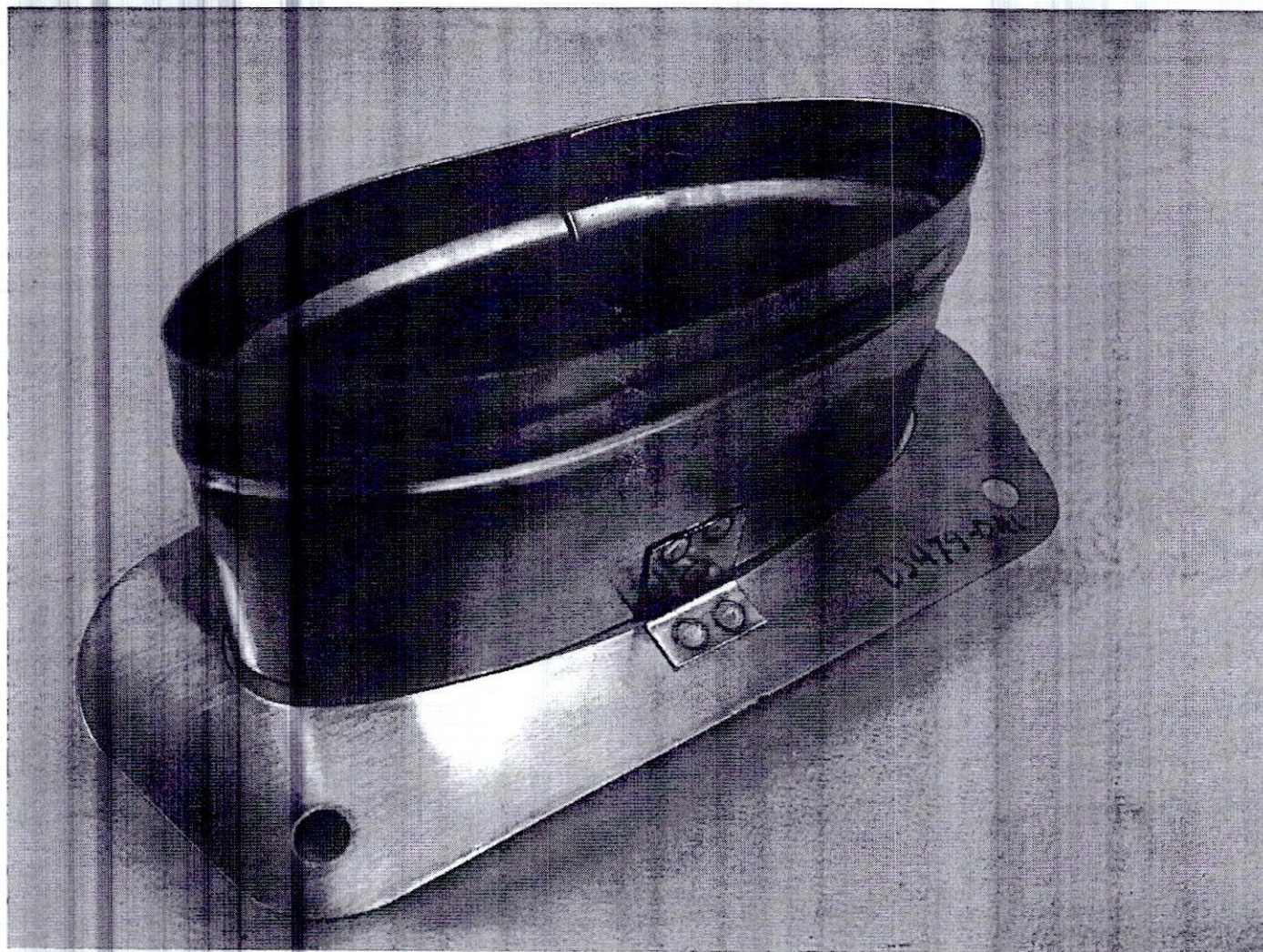
**SECTION A-A****D3479-041 INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 018
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3479-041	INLET ADAPTER
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

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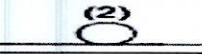
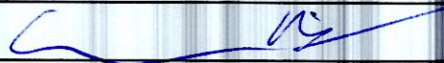


PAGE 1 OF 3]

VERIFICATION - RAW MATERIALS, SPECIFICATIONS, SPECIAL PROCESSES AND FUNCTIONAL TESTING.

[illegible]

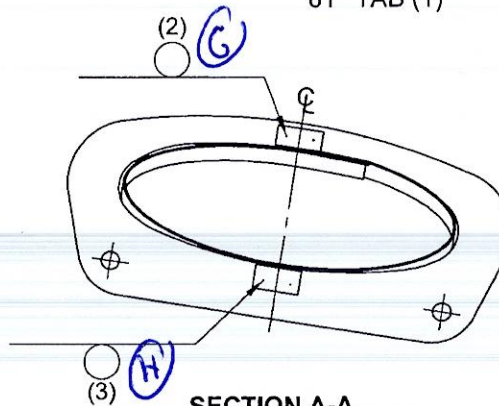
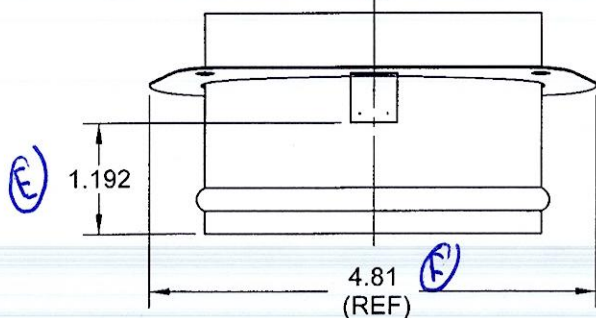
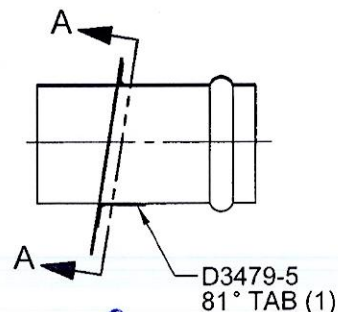
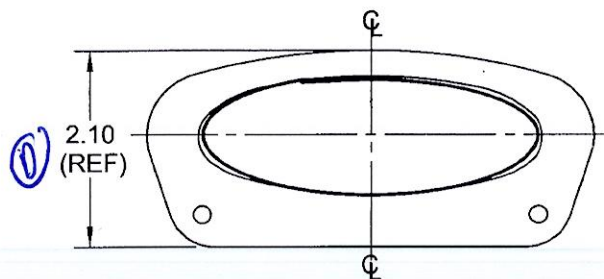
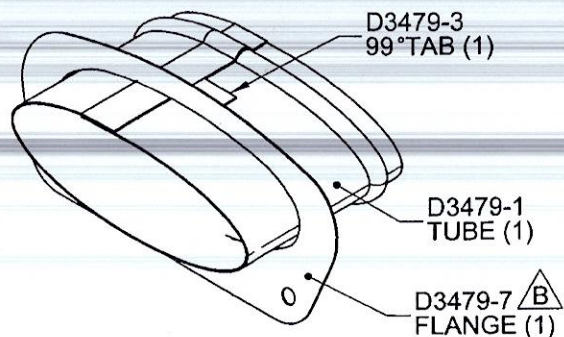
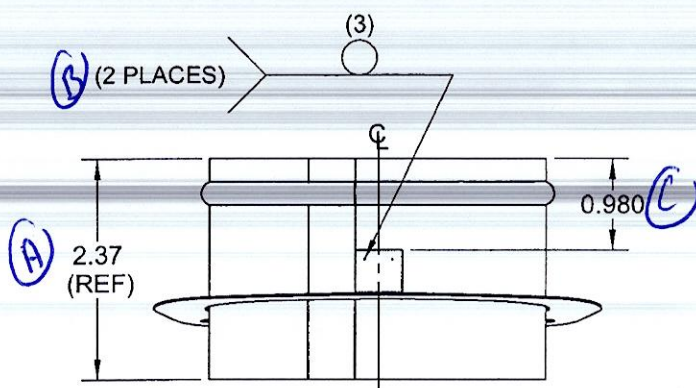
INSPECTION AND CONTROL (FAI 3) FEATURES, VERIFICATION AND COMFORMANCE EVALUATION

1. PART NUMBER		2. PART NAME		3. SERIAL NUMBER		4. FAI REPORT NUMBER	
D3479-041		INLET ADAPTER		N/A		625-1	
CHARACTERISTIC ACCOUNTABILITY				INSPECTION / TEST RESULTS			
6. CHARC #	6. REFERENCE LOCATION	7. CHARACTERISTIC DESIGNATOR	8. REQUIREMENTS	9. RESULTS	10. DESIGNED TOOLING	11. NON-COMFORMANCE NUMBER	14. COMMENTS
A	N/A	N/A	2,37 ±0,030	2,5	VERNIER 207	N/A	See waiver 2017-02-15
B	N/A	N/A	(2 PLACES) 	-3	VISUAL	N/A	N/A
C	N/A	N/A	0,98 ±0,030	0,975	VERNIER 207	N/A	N/A
D	N/A	N/A	2,1 ±0,030	2,125	VERNIER 207	N/A	N/A
E	N/A	N/A	1,192 ±0,010	1,192	VERNIER 207	N/A	N/A
F	N/A	N/A	4,81 ±0,030	4,805	VERNIER 207	N/A	N/A
G	N/A	N/A		PASS	VISUAL	N/A	N/A
H	N/A	N/A		(2)	VISUAL	N/A	See waiver 2017-02-15
I	N/A	N/A	SPOT WELD PER DART QSI 004	PASS	VISUAL	N/A	N/A
J	N/A	N/A	FINISH: NONE	N/A	N/A	N/A	N/A
K	N/A	N/A	IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER	PASS	VISUAL	N/A	N/A
L	N/A	N/A	TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED	PASS	N/A	N/A	N/A
M	N/A	N/A	ALL DIMENSIONS ARE IN INCHES	PASS	N/A	N/A	N/A
N	N/A	N/A	BREAK ALL SHARP EDGES 0,005 TO 0,010	PASS	FEEL	N/A	N/A
THE SIGNATURE INDICATES THAT ALL CHARACTERISTICS ARE ACCOUNTED FOR; MEET DRAWING REQUIREMENT OR ARE PROPERLY DOCUMENTED FOR DISPOSITION.							
12. PREPARED BY: 					13. DATE: 2017-02-17		



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. B SHEET 1 OF 4
DATE 08.12.19		TITLE INLET ADAPTER	SCALE 1:2
A	06.01.19	NEW ISSUE	
B	08.12.19	CORRECT TYPO ON SHT1; ADD TOL ON SHT2; MATL SPEC WAS MIL-S-5019	

RELEASED
09/01/30



D3479-041 INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 018 (I)
- 2) FINISH: NONE (J)
- 3) IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER (K)
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED (L)
- 5) ALL DIMENSIONS ARE IN INCHES (M)
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 (N)

QTY -041	P/N	DESCRIPTION
X	D3479-041	INLET ADAPTER
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

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RESISTANCE WELDING DATA SHEET AND PQR N° RW-2

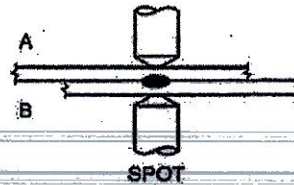
Equipment Identification

Manufacturer: Techno Control

Model: Alpha Series

S/N 3187 Rating 50%

Operator: Frederick Gaudreau



		SIDE A	SIDE B	SPOT	
MATERIAL	Thickness	0.018"	0.018"	S.C.R.	On
	Approx. Analysis (type)			Squeeze Time (s)	60
				Cool Time (s)	0
	Surface Cond.	Clean *	Clean *	Heat (%)	45
	Ultimate Strenght	N/A	N/A	Hold Time (s)	6
	Yield Strenght	N/A	N/A	Off Time (s)	6
	Elongation %			Squeeze Force (Psi)	45
	Red. In Area %			Weld Time (s)	10
	Hardness				
	Material	AISI 304/316	AISI 304/316		
ELECTRODE	Shape			Tension Test	
	W = 5/8"			TORSIONNAL Yield Point Ultimate Mod. Of Rupt. Degree Twist at Ult.	
	E = 13/64"				
	r = N/A				
alpha = N/A					
SPOT	Diameter: 3/16" min.	Shear Load Result 1: 560 Lb 2: 558 Lb 3: 535 Lb 4: 5:			
	Overlap or Flange: 0.7" min.				
	Spacing: As per drawing				
	Roll Speed mm per min. (in. per min.)				
SEAM	Spots per mm (in)	Indentation: Less than 0.005" Nugget Size: Over 0.09" Other Tests: See lab report M17011208			
	Width of Weld				
	Overlap or Filler				
MASH	Length of Weld	Photos or sketch 			
Remarks: Dart Aerospace Ref.: 229 *Clean with alcohol					

 Company Lev-Fab Inc.
 Authorized By Denis Martel Ing.

Signature


 Denis Martel
 CWI 14110007
 QC1 EXP. 11/1/2017



GENITEST INC.



LABORATOIRE D'ESSAIS (Métaux, Matériaux) CONSULTATION - RECHERCHE
TESTING LABORATORY (Metals, Materials) CONSULTING - RESEARCH

AEROSPACE LEV-FAB
640 Boul. Mgr Dubois
St-Jérôme, QC
J7Y 3L8

Report Date January 19, 2017
Page 1 of 2

TEST REPORT EVALUATION OF RESISTANCE SPOT WELDING PROCEDURE CERTIFICATION

M17011208

Customer #: A001206		Macroscopic and metallographic examination			
Material: Group 2 Weld Class C		Thickness # 1: 0.018"			
		Thickness # 2: 0.018"			
		W=0.73"; L=3.0"			
Shape: Isolated Spot Weld Sheet Test specimens		Sample	# 3	# 4	Acc. Rej.
Thick. # 1 (sheet):---		Contacting Overlap (min. 0.68")	0.73"	0.73"	☒ ☐
Thick. # 2 (sheet):---		Edge distance (0.365" ± 0.060") - 1:	0.375"	0.365"	☒ ☐
Welder:---		-2:	0.355"	0.365"	☒ ☐
W/O:---		Surface Indentations T1 (max. 0.005"):	0.002"	0.002"	☒ ☐
Testing time:---		Surface Indentations T2 (max. 0.005"):	0.003"	0.002"	☒ ☐
Other: ---		Penetration T1 - minimum (min 20% T):	51% T (*)	48% T (*)	☒ ☐
Testing Specifications:		-maximum (max 90% T):	62% T	59% T	☒ ☐
AWS D17-2/D17.2M:2013		Penetration T2 - minimum (min 20% T):	53% T (*)	45% T (*)	☒ ☐
=====		-maximum (max 90% T):	65% T	53% T	☒ ☐
Visual Inspection		Sheet separation (max. 0.006")-Left side:	<0.001"	0.003"	☒ ☐
ACCEPTED		-Right side	0.003"	<0.001"	☒ ☐
		Discontinuities from the edge of the nugget:	Nil	Nil	☒ ☐
		(Max. : 15% of the nugget radius)	0.009"	0.008"	☒ ☐
		Discontinuities extending into outer sheet:	Nil	Nil	☒ ☐
		(Max.: 50% of the sheet thickness)	0.009"	0.009"	☒ ☐
		The largest discontinuity:	Nil	Nil	☒ ☐
		(Max.: 25% the nugget diameter)	0.029"	0.027"	☒ ☐
		Effective weld nugget size (min. 0.090"):	0.116"	0.107"	☒ ☐
		Penetration and Annulus Zone (figure 7):	Clear	Clear	☒ ☐

ENVIRONMENTAL CONDITIONS DURING TEST

Temperature: 24°C

Pressure: n/a

Relative Humidity: 23%

Comments: Conforming with AWS D17.2/D17.2M:2013.

The thickness of the sheets was measured by Genitest.

(*) More than 80% of the measured nugget diameter exceeds the minimum penetration requirement.

See the next page for supplemental information

TEST DONE IN ACCORDANCE WITH MCLM FC-23 E and BAERD-GEN-018E

ALL INSTRUMENTS ARE CALIBRATED USING STANDARDS AND MEASURING DEVICES TRACEABLE TO NIST (NBS). TECHNICAL PROCEDURES AND SPECIFICATIONS RELATIVE TO Nadcap QUALITY STANDARDS HAVE BEEN FOLLOWED FOR THIS REPORT.

Liability: Genitest Testing's liability to the client or any third party is limited to the amount charged for services provided.

The test report shall not be reproduced except in full, without the written approval of Genitest Inc. and the recording of false, fictitious, or fraudulent statements or entries on the certificate may be punished as a felony under federal law.

Subcontractor: Nil

Document #GT-WF311-02

Jean Lavoie, PE Metallurgist

3472 Frontenac - Montreal, Qc - H2K 3A5 Tel: (514) 526-8378 - Fax: (514) 526-5904

Supplemental Information

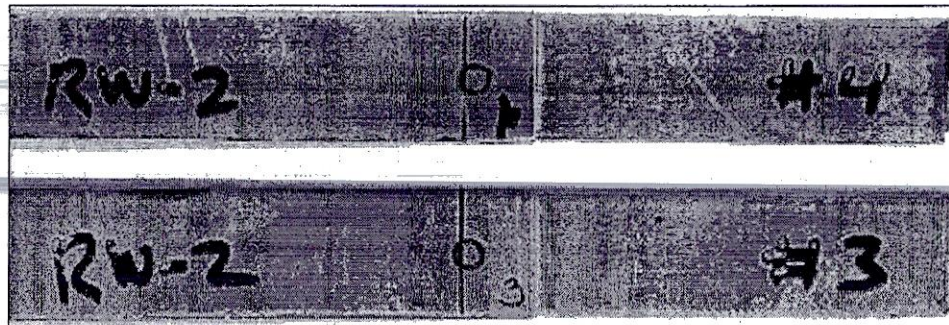


Figure 1 – Specimens as received for metallographic evaluation

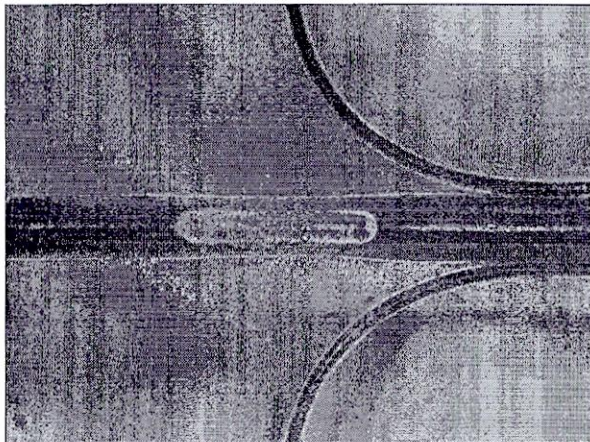


Figure 2 – Transverse section through the mid of the spot weld no 3 – Etchant: Vilella's - Magnification 10x 1 mm

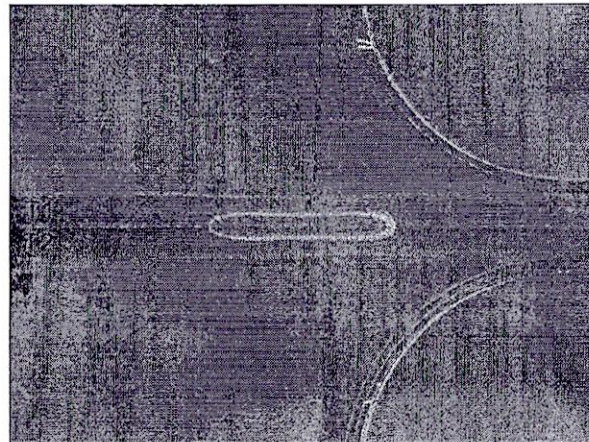


Figure 3 – Transverse section through the mid of the spot weld no 4 – Etchant: Vilella's - Magnification 10x 1 mm





GENITEST INC.

Accredited
NadcapTM
Material Testing Laboratory

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TESTING LABORATORY (Metals, Materials) CONSULTING - RESEARCH

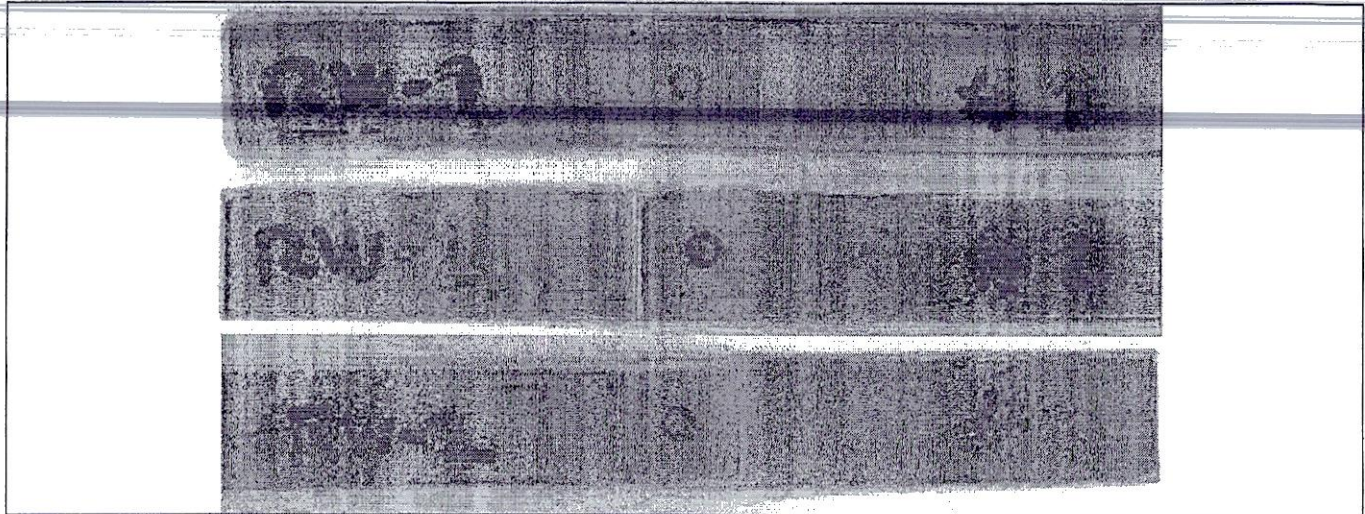
AEROSPACE LEV-FAB
640 Boul. Mgr Dubois
St-Jérôme, QC
J7Y 3L8

Report Date
Page

January 19, 2017
1 of 1

**TEST REPORT
SHEAR TEST**

L17011208



<i>Customer #:</i> A001206	<u>Sample #:</u>	<u>LOAD</u>
<i>Specification:</i> AWS D17-2		(lb _f)
<i>Material:</i> ---	1	560
<i>Shape:</i> Shear test sample	2	558
<i>Dimensions:</i> 0.018" thick.	5	535
<i>Testing Spec.:</i> ASTM E8-15	Average	551

ENVIRONMENTAL CONDITIONS DURING TEST
Comments:

Temperature: 21°C

Pressure: n/a

Relative Humidity: 24%

TEST DONE IN ACCORDANCE WITH MCLM F-23C and BAERD-GEN-018E

ALL INSTRUMENTS ARE CALIBRATED USING STANDARDS AND MEASURING DEVICES TRACEABLE TO NIST (NBS).
TECHNICAL PROCEDURES AND SPECIFICATIONS RELATIVE TO Nadcap AND ISO/IEC 17025 QUALITY STANDARDS HAVE BEEN FOLLOWED FOR THIS REPORT.
Limited Liability: Genitest Testing's liability to the client or any third party is limited to the amount charged for services provided.
The test report shall not be reproduced except in full, without the written approval of Genitest Inc. and the recording of false, fictitious, or fraudulent statements or entries on the certificate may be punished as a felony under federal law.

Subcontractor: NIL

Document #GT-ED311-02

Jean Lavoie, PE Metallurgist

3472 Frontenac - Montreal, Qc - H2K 3A5 Tel: (514) 526-8378 - Fax: (514) 526-5904



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34695**

Purchase Order Date 12/20/2016

PO Print Date 12/20/2016

Page Number 1 of 2

Order From :

VC-ALF01

Ship To : DART AEROSPACE LTD

AEROSPACE-LEV-FAB

1270 ABERDEEN

640 BOUL. MGR. DUBOIS

HAWKESBURY, ON K6A 1K7

ST JEROME, QUEBEC J7Y 3L8

CANADA

Contact Name

Buyer

Linda Lacelle

Vendor Phone

514-876-8787

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

FedEx Economy collect

FOB

Destination-Collect

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	154263	D3480-041	1/10/2017 No 1/10/2017		2.00	\$0.00	\$0.00
	spot weld per drwg and QSI005						
						Line Total:	\$0.00
2	154262	D3480-043	1/10/2017 No 1/10/2017		2.00	\$0.00	\$0.00
	spot weld per drwg and QSI005						
						Line Total:	\$0.00
3	154264	D3479-041	1/10/2017 No 1/10/2017		2.00	\$0.00	\$0.00
	spot weld per drwg and QSI005						

PO Instructions: Fedex Acct # 151793240

Note:

12/20/2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34695**

Purchase Order Date 12/20/2016

PO Print Date 12/20/2016

Page Number 2 of 2

Order From :

VC-ALF01

Ship To : DART AEROSPACE LTD

AEROSPACE LEV-FAB

1270 ABERDEEN

640 BOUL. MGR. DUBOIS

HAWKESBURY, ON K6A 1K7

ST JEROME, QUEBEC J7Y 3L8

CANADA

Contact Name

Vendor Phone

514-876-8787

Buyer

Linda Lacelle

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Ship To Phone

Ship Via:

FedEx Economy collect

Ship Acct:

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: \$0.00

4	71401-45	PROCUREMENT QUALITY CLAUSE	1/10/2017	1.00	\$0.00	\$0.00
---	----------	-------------------------------	-----------	------	--------	--------

No

1/10/2017

Procurement Quality Clauses

A004 faa-pma/tso

A005 right of entry

A008 first article inspection (FAI documentation maintained by
seller Documentation sent to Dart Aerospace)

A016 personnel qualification

A026 certification of materila conformance

A040 notification of escape clauses

A042 dart notification by supplier

A043 retention of quality document

Line Total: \$0.00

5	71401-45	FAI - 2 samples B154684	1/10/2017	2.00	\$0.00	\$0.00
---	----------	-------------------------	-----------	------	--------	--------

No

1/10/2017

Line Total: \$0.00

PO Total: \$0.00

PO Instructions: Fedex Acct # 151793240

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 12/20/2016

DART AEROSPACE LTD

QUALITY SYSTEM INSTRUCTION: QSI 018

TITLE: Standard Tolerances

ISSUE: 03

DATE: November 30, 2004

PREPARED BY: David Shepherd

REVIEWED

**Linda Lacelle
PRODUCTION MANAGER**

**David Shepherd
CHIEF ENGINEER**

**Bill Beckett
DESIGN MANAGER**

APPROVED BY:

**Susanne Sheldon
DIRECTOR, QUALITY ASSURANCE**

STANDARD TOLERANCES

Procedure Issue Date: 04.11.30 Issue No: 03

1.0 PURPOSE

To establish the tolerances for DART production

2.0 SCOPE

This work instruction applies to all parts manufactured, or designed by DART, unless otherwise stated on a drawing

3.0 RESPONSIBILITY**3.1 PRODUCTION MANAGER**

Has the responsibility of ensuring the tolerances are being followed

3.2 DIRECTOR, QUALITY ASSURANCE

Is responsible for auditing that the tolerances are being followed.

4.0 PROCEDURE**4.1** Follow the following requirements (unless otherwise stated):

1. Dimensions are in inches.
2. Surface roughness 125✓. (Visual inspection accepted).
3. Remove sharp edges .015 max.
4. Threads per MIL-S-7742
5. Holes per the following table: (source: AND10387)

Hole Diameter	Tolerance
0.0135 to 0.125	+ 0.004 / - 0.001
0.126 to 0.250	+ 0.005 / - 0.001
0.251 to 0.500	+ 0.006 / - 0.001
0.501 to 0.750	+ 0.008 / - 0.001
0.751 to 1.000	+ 0.010 / - 0.001
1.001 to 2.000	+ 0.012 / - 0.001

6. Dimensions:

X.X	+/- 0.100
X.XX	+/- 0.030
X.XXX	+/- 0.010
7. Angles

	+/- 1/2°
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8. Parallelism

	+/- 0.0025
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9. Eccentricity

	0.005 Max
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10. Symmetry about all M/C center lines

	0.005
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STANDARD TOLERANCES

Procedure Issue Date: 04.11.30 Issue No: 03

REVISION RECORD: B

PAGE	PAGE REV.	SUBJECT	DATE	INITIAL	DQA
1	A	No change			
2	B	Revised issue page	06.08.03		
3	B	Revised Section 4.1	06.08.03		